



GMAW COPPER ALLOYS
AUTOMIG CuSn-A

PHOSPHOR BRONZE SOLID WIRE FOR MIG WELDING



CLASSIFICATION : AWS A/SFA 5.7

ERCuSn-A

KEY FEATURES :

- Copper-Tin solid wire
- Good resistance against corrosion and overheating
- Weld pool should be kept small to reduce hot short cracks
- For thick section, preheating is recommended
- Tin increases the wear resistance of the weld and slows the rate of solidification
- Rapid cooling at room temperature recommended
- Weld deposit easily machinable
- Radiographic quality welds

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
Ar or Ar/He	15-20	10-20

TYPICAL APPLICATIONS :

- Welding of similar base metals such as 509 to 519 series tin bronze alloys
- Bronze, brass and copper welding
- Overlay welding on steel, casting repair

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	Sn	P	Al	Pb	Cu+Ag
Specification	4.0-6.0	0.10-0.35	0.01 max	0.02 max	Bal.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	Average Brinell Hardness, HBW
Specification	As Welded	240 min	70-85

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA :

Ø x L, mm	Kg/Spool
1.2	12.5
1.6	12.5

EQUIVALENT :

SMAW Electrode: **Bronze**