

TECHNICAL SHEET

Silicon Bronze

BEIDUO® Alloys

Providing Complete Brazing, Soldering & Welding

No.:000028

Classification

AWS A5.7 ERCu
EN 13347 CuSn1

Chemical Composition: %

Cu	Sn	Mn	Si	P	Al	Pb	Other
Balance	1.0	0.5	0.5	0.15	≤0.5	0.5-1.5	≤0.5

Mechanical and physical properties

Melting range: 1020-1070 °C

Tensile strength: 160-180N/mm²

Elongation: 29 %

Hardness: 255HB

Welding process:

TIG , MIG, gas flame torch, induction and resistance heating

Description and Applications

The ERCu alloy is easy flowing and produces weld deposits that are porosity free, electrically conductive and the color will match that of copper. The oxyacetylene gas flame must be neutral or slightly oxidizing. Tip size must be one to two sizes larger than the base plate. Preheating should be done only if the part is thick. A boric acid or borax flux.

Joining deoxidized copper, electrolytic tough pitch copper and repair weld copper castings with MIG, TIG, and oxyacetylene welding processes. Welding galvanized steel and deoxidized copper to mild steel where high strength joints are not required. Overlaying steel surfaces to resist corrosion. Joining copper pipes, tanks and copper fittings.

Availability

Rods: ϕ 1.5-5.0mm Max.Length: 1000mm

Wire: ϕ 1.0, 1.2, 1.6mm on spools D300

Other dimensions are available upon request

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