



## PRODUCT INFORMATION

### SIFPHOSPHOR BRONZE No 8

EN 14640: Cu 5180 (CuSn6P)  
BS: 2901: C11

## DESCRIPTION

A phosphor-bronze rod containing 7% tin and suitable for fusion welding of phosphor bronze castings, copper alloys and brass in oxy/acetylene welding. Sifphosphor Bronze No 8 is also used for TIG brazing on ferrous, stainless and dissimilar metals.

## WELDING POSITIONS



Weldable in all positions and particularly suitable for welding around pipes (with wall thickness >1.6mm). Ensure surfaces of parent metal are cleaned thoroughly before welding.

## TYPICAL WELD METAL COMPOSITION

|    |     |
|----|-----|
| Sn | 7 % |
| Cu | Bal |

## TYPICAL MECHANICAL PROPERTIES

|                      |                       |
|----------------------|-----------------------|
| Melting Point        | 900-1050 °C           |
| Ult Tensile Strength | 260 N/mm <sup>2</sup> |
| Hardness BHN         | 80                    |

## MATERIAL TO BE WELDED

Commonly used in oxy/acetylene on bronze, brass, copper and copper alloys for applications such as crack repair in castings. The use of flux is normally unnecessary in most applications, but Sifbronze Flux can be beneficial in aiding flow when used on copper which is dirty or oxidised.

Where parent metal contains trace lead (such as in LG2), it is advisable to use Sifphosphor Bronze No 8 in the TIG Brazing process, and apply in stages, grinding between passes to remove lead drawn into the joint and reduce porosity.

## AVAILABLE FORMATS

| 1M ROD (TIG / GTAW & OXY/ACETYLENE) |          |           |           |
|-------------------------------------|----------|-----------|-----------|
| Dia                                 | 1kg Pkt  | 2.5kg Ctn | 5.0kg Ctn |
| 1.2mm                               | RO081201 | RO081225  | RO081250  |
| 1.6mm                               | RO081601 | RO081625  | RO081650  |
| 2.4mm                               | RO082401 | RO082425  | RO082450  |
| 3.2mm                               | RO083201 | RO083225  | RO083250  |

|                       |            |
|-----------------------|------------|
| Shielding Gas (TIG) : | Pure Argon |
|-----------------------|------------|

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@wholeweld.co.uk**



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