



PRODUCT INFORMATION

SIFMIG 968

EN 14640 Cu 6560 (CuSi3Mn1),
 BS: 2901 C9
 AWS A5:7 ERCuSi-A

DESCRIPTION

A copper wire containing 3% silicon and 1% manganese used for fusion welding materials of similar composition, copper alloys (brass) and for MIG brazing steels. It is also suitable for surfacing steel and dissimilar metal applications. The silicon and manganese provide good flow properties and wear-resistance.

WELDING POSITIONS



Suitable for use in various industries, including ship building and offshore, automotive, heating and ventilation. Can also be used in sculpture making and repair, the manufacture of bronze statues and castings and tubular products.

TYPICAL WELD METAL COMPOSITION

Mn	1 %
Si	3 %
Cu	Bal

TYPICAL MECHANICAL PROPERTIES

Melting Point	980-1020 °C
Ult Tensile Strength	350 N/mm ²
Hardness	90

MATERIAL TO BE WELDED

SIF MIG 968 is the choice material for the manufacture and repair of motor vehicles (see p.128 of our catalogue on MIG brazing). Frequently used to weld steels and cast-iron to copper, brass and bronze. Can be used on galvanized steels. This product also provides good colour match on silicon. Pulsed MIG is recommended.

AVAILABLE FORMATS

SPOOLED WIRE (MIG / GMAW)			
Dia	0.7kg	4.0kg	12.5kg
0.8mm	WO960807	WO960840	WO960812
1.0mm	WO961007	WO961040	WO961012
1.2mm		WO961240	WO961212

Current DC = +
Amps: 35-180
Gas: Pure Argon
1% O2 Argon for MIG brazing

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

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