



## PRODUCT INFORMATION

### SIFMIG 8

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

### DESCRIPTION

A phosphor bronze wire containing 7% tin and is suitable for fusion welding of phosphor bronze castings and copper alloys, and brass. It is also used for MIG brazing on ferrous, stainless and dissimilar metals or for applying a bearing surface.

### WELDING POSITIONS



Weldable in all positions and particularly useful in hard-to-reach areas. 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	80

### MATERIAL TO BE WELDED

Popularly used on bronze, brass, copper and copper alloys for applications such as crack repair in castings, and to provide a wear-resistance layer on surfaces subject to abrasion. Where parent metal contains trace lead (such as LG2), it is advisable to apply SIFMIG 8 in stages, grinding between passes to remove lead drawn into the joint and to reduce porosity.

### AVAILABLE FORMATS

SPOOLED WIRE (MIG / GMAW)			
Dia	0.7kg	4.0kg	12.5kg
0.8mm	WO080807	WO080840	WO080812
1.0mm	WO081007	WO081040	WO081012
1.2mm	WO081207	WO081240	WO081212

Current :	DC = +
Shielding Gas :	Pure Argon, or 95/5 (5%CO <sub>2</sub> ) ArCO <sub>2</sub>

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

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