



# Tin Bronze Filler Wire

## Joining of Similar Alloys

AWS A5.7 ER CuSn-A~  
BS 2901 1990 Pt3: C11

### CW-1800

#### DESCRIPTION & APPLICATION

MIG/TIG Filler Wire for the repair and reclamation of Tin Bronzes, Phosphor Bronze and Gunmetal. Also suitable for the joining of Cast Iron to Mild and low Alloy Steels and overlay of such material.

#### BASE MATERIALS

Phosphor Bronze, Gunmetal, Tin Bronze.  
Joining of Mild and Low Alloy Steel. Overlay and joining of Cast Iron, Mild/Cast Steel. Joining of Galvanised Sheet.

#### MECHANICAL PROPERTIES

290	150	25	~100
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HB

#### METAL WELD COMPOSITION %

<b>Cu</b>	<b>Si</b>	<b>Sn</b>	<b>Al</b>	<b>P</b>	<b>Pb</b>
BAL	0.02	7.5	0.03	0.03	0.02

#### PACKAGING

15kg Spools (MIG)  
5kg Tubes (TIG)

#### DIAMETERS

0.8, 1.0, 1.2mm (MIG)  
1.6, 2.4, 3.2mm (TIG)

#### WELDING INSTRUCTIONS

Shielding Gas Pure Argon or Argon/Helium. Weld with Dip transfer where possible. Do not overheat base material. Fill all craters.

**For more details on welding of Copper Alloys, please see our Information Sheets.**  
**Visit:** [www.westbrookwelding.co.uk/downloads](http://www.westbrookwelding.co.uk/downloads)