



Silicon Bronze Filler Wire

MIG Brazing

AWS A5.7 CuSi-A
BS 2901 1990 Pt3: C9

CW-1820

DESCRIPTION & APPLICATION

MIG/TIG Filler Wire for the repair and reclamation of Silicon Bronzes, Phosphor Bronze, Gunmetal and Brass. Also suitable for the joining of Cast Iron to Mild and Low Alloy Steels, and overlay of such material. In MIG form, commonly referred to as MIG Brazing wire, used in Motor Vehicle repair and assembly.

BASE MATERIALS

Copper and Copper alloys, Silicon Bronze, Gunmetal, Tin Bronze, Brass. Joining of Thin Mild and Low Alloy Steel. Overlay and joining of Cast Iron, Mild/Cast Steel. Galvanised Steel, Boron Steel (Motor Industry). Joining of Galvanised Sheet.

MECHANICAL PROPERTIES

~350 UTS n/mm	~145 YIELD 0.2%	30 ELONG A5%	~90 HARDNESS HB
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METAL WELD COMPOSITION %

Cu BAL	Si 3.0	Mn 1.1	Al 0.03	Fe 0.1	Pb 0.01
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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.

For more details on welding of Copper Alloys, please see our Information Sheets.
Visit: www.westbrookwelding.co.uk/downloads