

Phos-C

Classification

AWS.A5.7 ERCuSn-C
UNS C52100

Description

TALWELD PHOS-C (ex China) and Phos-C Weld (ex USA) wires contain 8% tin. They are harder and stronger than AWS 5.7 ER CuSn-A, and are preferred for welding phosphor bronzes, high strength bronzes and brasses. The alloys' colour matches phosphor bronze very well.

Application

TALWELD PHOS -C and Phos-C Weld wires can be used for repairs to gun-metal, phosphor bronze, aluminium bronze and silicon bronze parts/components, including Bronze ship propellers, bearing surfaces, impeller blades and other castings. They can also be used for joining copper alloys to steel and may be also be used for some cast irons.

Shielding Gas

Welding grade Argon or Argon/Helium mixtures

Chemical Composition of Solid Wire

Cu	Zn	Sn	Fe	P	Al	Pb	Total Others
Balance	0.20 Max.	7.0 – 9.0	0.10 Max.	0.10 – 0.35	0.01 Max.	0.02 Max.	0.50 Max.

Typical Mechanical Properties of Weldmetal

Tensile strength	Yield strength	Elongation
480 MPa	320 MPa	24%

Packaging and Machine Settings – GMAW

Diam. (mm)	1.2
Spool (300mm)	13.6 kg
Volts	21-28
Current, A	160-240

Diam.	13.6kg Spool Talweld Phos-C	13.6kg Spool Phos-C Weld
1.2mm	CMCPHOS-C12	CMWPHOS-C12

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com E: sales@talarc.com