



Phos-Bronze C (ERCuSn-C)

Unibrazed Phos-Bronze C is recommended for high strength welds on phosphor bronze materials. Weld deposits have high tensile and yield strengths and greater hardness due to the 7 to 9 percent Tin content. It is used as an overlay on cast iron or steel, to join dissimilar metals, for maintenance repair and fabrication of valve bodies, seats, bearings, bushings, gears, propellers, impeller blades and housings. Preheat is recommended. Recommended shielding gas is Argon, or 75Helium/25Argon.

Typical Chemical Composition

Copper*	Balance
Zinc	0.20 max.
Tin	7.0 – 9.0
Iron	0.10 max.
Lead	0.05 max.
Phosphorus	.03 – 3.50
Others	0.50 max.

*includes Silver

Typical Mechanical Properties

Tensile Strength	65,000 psi, min. 457 MPa
Elongation, in 2 in.	42%
Brinnell Hardness	80 to 100

Specifications

AWS A5.7 / ASME SFA5.7 Class ERCuSn-C

Available Sizes

MIG: .035" (.9mm), .045" (1.2mm), .062" (1.6mm)

TIG: 1/16" (1.6mm), 3/32" (2.4mm), 1/8" (3.2mm)