

## PRODUCT INFORMATION

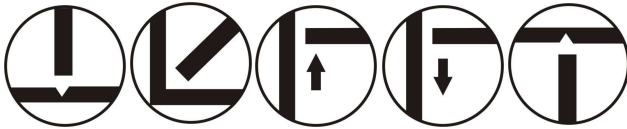
### SIFSILCOPPER No 968

EN 14640 Cu 6560 (CuSi3Mn1),  
BS: 2901 C9

### DESCRIPTION

A copper rod, containing 3% silicon and 1% manganese used for fusion welding materials of similar composition, copper alloys (brass) and for TIG brazing steels. It is also suitable for surfacing steel and dissimilar metal applications. Excellent performance on galvanized steel and provides good corrosion-resistance.

### WELDING POSITIONS



Suitable for use in the ship building/offshore industries as well as the heating and ventilation industries for corrosion resistance, and tubular product fabrication. Can also be used for sculpture repair.

### TYPICAL WELD METAL COMPOSITION

|    |     |
|----|-----|
| Mn | 1 % |
| Si | 3 % |
| Cu | Bal |

### TYPICAL MECHANICAL PROPERTIES

|                      |                       |
|----------------------|-----------------------|
| Melting Point        | 980-120 °C            |
| Ult Tensile Strength | 350 N/mm <sup>2</sup> |
| Hardness             | 90                    |

### MATERIAL TO BE WELDED

Oxy-acetylene gas flame should be slightly oxidizing. Keep the weld puddle small in order to promote fast solidification and minimize cracking. In oxy-acetylene welding, SIF Sil copper flux should be used both before and during welding. Preheat is not recommended. Can be used in oxy-acetylene for fusion welding of copper alloys and brass. Also popularly used in TIG for brazing steel and cast iron to copper, brass and bronze.

### AVAILABLE FORMATS

| 1M ROD (TIG / GTAW) |          |           |           |
|---------------------|----------|-----------|-----------|
| Dia                 | 1kg Pkt  | 2.5kg Ctn | 5.0kg Ctn |
| 1.2mm               | RO961201 | RO961225  | RO961250  |
| 1.6mm               | RO961601 | RO961625  | RO961650  |
| 2.4mm               | RO962401 | RO962425  | RO962450  |
| 3.2mm               | RO963201 | RO963225  | RO963250  |

|                          |
|--------------------------|
| Oxy-acetylene            |
| TIG current DC: = +      |
| Amps: 70-320             |
| Gas: Pure Argon 15-20lpm |

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email [service@wholeweld.co.uk](mailto:service@wholeweld.co.uk)



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