



EWB[®] – ER CuSn-A MIG / TIG Welding Wires

Classifications:

AWS A5.7: ERCuSn-A

ISO 24373: CuSn5P

Typical Chemistry Composition of Weld Deposit (%):

Cu	P	Sn	Al	Pb	Others
Balance	0.10 – 0.35	4.00 – 6.00	<0.01	<0.02	<0.50

Description & Applications:

- ENAR Phos-Bronze CuSn-A filler metal is used for MIG and TIG welding of tin-bronze base metals such as 509 to 519 series, for brass and for overlay welding of steel.
- Phos-Bronze A contains approximately 5% tin and up to 0.35% phosphorus.
- The tin content increases the wear resistance of the weld deposit while the phosphorus acts as a deoxidizer.

Typical Mechanical Properties:

Tensile Strength (N/mm ²)	Hardness (HB)	Melting Temperature (°C)
240	70 - 85	1050

Shielding Gas: Ar

Welding Parameters:

Wire Diameter (Ø in mm)	0.80	1.00	1.20
Current (A)	60 – 165	80 – 210	150 – 320
Voltage (V)	13 – 17.5	12.5 – 18	16 – 29

Packing Available:-

MIG/MAG Wire (Ø in mm): 0.80 / 1.00 / 1.20

TIG Wire (Ø in mm): 1.60 / 2.40 / 3.20 / 4.00

EWB Weld

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An ISO 9001:2015 Quality Management System Certified Co.