



## EWB<sup>®</sup> – ER CuSn-C MIG / TIG Welding Wires

### Classifications:

AWS A5.7: ERCuSn-C

### Typical Chemistry Composition of Weld Deposit (%):

Cu	Zn	Fe	Pb	P	Sn	Others
Balance	<0.20	<0.10	<0.05	0.03 – 0.35	7.00 – 9.00	<0.50

### Description & Applications:

- ENAR Phos-Bronze CuSn-C filler metal is used quite extensively for surfacing applications.
- The higher tin (Sn) content (7.0 - 9.0%) gives excellent weld deposits, greater hardness and higher tensile/yield strength than ENAR Phos-Bronze CuSn-A.
- It is commonly used for base metals of similar composition, for joining brass alloys and for joining cast iron to carbon steel.

### Typical Mechanical Properties:

Tensile Strength (N/mm <sup>2</sup> )	Hardness (HB)	Melting Temperature (°C)
280	68 - 83	1026

### 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

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