

IABCO C11

MIG/GMAW and TIG/GTAW copper base wire

Product name	IABCO C11
Classification EN ISO	24373: Cu5180A (CuSn6P)
Classification AWS	A5.7: ERCuSn-A (nearest)
Classification BS	2901 pt 3: C11 (obsolete specification)
Applications	A tin bronze (phosphor bronze) wire with approximately 6% tin. The IABCO C11 wire can be used for welding a wide range of copper alloys ranging from phosphor bronze, brass, manganese bronze and gunmetal. The wire can also be used for surfacing. The IABCO C11 wire provides a good colour match for many of the brasses.
Base materials	Used for welding tin bronze (phosphor bronze) alloys, eg: C51000, C511000, C51900, CuSn4, CuSn5, CuSn6. Gunmetal, eg: C83600, C92200 (5% Pb alloys can cause problems). Brasses, eg: C27400, CuZn37.
Typical analysis of wire, weight %	Cu: Balance Sn: 6.2 P: 0.15
Typical heat treatment ⁽¹⁾	Preheat: A preheat of 200°C may be required particularly with thicker section material. Interpass: Should be kept to 200°C.
Typical mechanical properties of weld ⁽²⁾	0.2% proof stress Rp0.2%: 120MPa Tensile strength Rm: 260MPa Elongation 5d: 20%
Other products	-

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.