



WBC27T TIG WELDING WIRE

Classifications	BS EN ISO 24373: Cu 5410 (CuSn12P) EN 14640: CuSn12P									
Product Description	WBC27T is a Phosphor bronze TIG wire for improved colour match on brass and bronze.									
All-Weld Metal Composition (Wt. %)	Cu	Sn	P	Al	Pb	Zn	Other			
min.	Bal.	11.0	0.01	-	-	-	-			
max.	-	13.0	0.40	0.005	0.02	0.05	0.40			
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength			N/mm ²		320				
	0.2% Proof Stress			MPa		-				
	Elongation on 4D			%		-				
	Hardness			BHN		120				
	Melting Range			°C		850-1000				

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	-	60	80	100
	max.	-	-	-	-	180	200	240
Volt Range (Volts)	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
Packaging Information								
Kg Per Tube		-	-	-	-	5.0	5.0	5.0
Storage	Storage It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
Gases	Gas Pure Argon (DC- or AC), Helium or Ar-He (DC-)							
	Flow Rate 12-14 L/min							

Current Conditions AC & DC- and Welding Positions

