



WBC27T TIG WELDING WIRE

Classifications	EN 14640 Cu 5410 (CuSn12P) BS2901 Part 3 : Grade C27								
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						
min.	Bal.	10.0	0.10						
max.	-	14.0	0.30						
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.	-	-	-	-	500	60	80
	max.	-	-	-	-	100	140	160
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 (AC), Helium or Ar-He (DC-)							
	Flow Rate 12-14 L/min							

Current Conditions AC & DC- and Welding Positions

