



TAURUS ERCUSI SILICON BRONZE TIG RODS

Description

TAURUS TIG SILICON BRONZE is pure copper filler rod deoxidised with 3% silicon for welding a wider range of copper alloys including overlaying of steels and cast irons. TAURUS TIG SILICON BRONZE should be shielded with pure argon but pure helium provides deeper penetration, higher travel speeds and allows reduced preheating.

APPLICATIONS

Applications include plate for chemical plant and moulds, stills and calorifiers, rods and wires for electrical components and tubes for heat exchangers.

MATERIALS TO BE WELDED

General purpose including phosphorous deoxidised copper, silicon bronze, nickel silver and some brasses.

WELDING POSITIONS

- Downhand
- Horizontal flat
- Horizontal vertical
- Vertical up
- Overhead

CLASSIFICATIONS

- AWS A5.7 ERCuSi-A
- DIN 1733 SG-CuSi3 (2, 1461)
- BS 2901Pt3 C9
- EN 24373 CU6560 CuSiMn1

COMPOSITION

	%
Silicon	2.8 – 4.0
Iron	0.3 Max
Manganese	0.75 – 1.5
Phosphorous	0.02 Max
Zinc	0.02 Max
Tin	0.2 Max
Lead	0.02 Max
Aluminium	0.01 Max
Other totals	0.4 Max
Copper	Balance

MECHANICAL PROPERTIES

Tensile strength	330 – 370 MPa
Elongation on 5d	40 % Max
Hardness	80 – 90 HB

AS WELDED

Product Category

1. Bronze
2. Consumables
3. Tig Rods

Date Created

03 Nov 2025