

FILLER METAL SELECTION TABLE FOR COPPER ALLOYS WELDING

PROPERTIES	PRODUCTS					
	56 FC 56B	57 FC 57B	516 T516/M8516	536 T536/M8536	561 (CA/CC+) 563 (CC+) T561/M8561	MCuSi3 TCuSi3
Tensile strength (x 1000 psi)	66	100	31	100	55 - 60	50
Hardness (as-welded) (BH)	115	200	55	185	100 - 120	70 - 80
Pure copper		1	1	2	3	1
Bronze		1		1	2	3
Brass	1	2			1	
Galvanized steels	1	2				1
Heterogeneous assemblies		1		1	2	2
Build up		2		1	2	
Wear resistance		2		1	2	
Electrical copper bus bars			1			2
Gear teeth		2		1	2	
Tin-bronze		1		2	1	
Thin sheet metal	1	2				1
Propellers		2		1	2	
Bronze pump casings		2		1	2	
Turbine build up		2		1		
Guides				1		
Valve seats		2		1	2	3

1 = Most efficient product(s)

Note:

This table is not exhaustive; other products may be suitable for certain applications and/or characteristics. Consult the **FSH Welding Canada** Technical Department.