

FILLER METAL SELECTION TABLE FOR COPPER ALLOYS WELDING

PROPERTIES	PRODUCTS							
	56 FC 56B	57 FC 57B	560 FC	516	536 T536 / MRS36	561 (CAUC+) 563 (C+)	MCUS3 T562	
Tensile strength (x 1000 psi)	66	100	85	31	100	55 - 60	50	
Hardness (as-welded) (BH)	115	200	130	55	185	100 - 120	70 - 80	
Pure copper		1	2	1	2	3	1	
Bronze		1	2		1	2	3	
Brass	1	2	3			1		
Galvanized steels	1	2						1
Heterogeneous assemblies		1	2		1	2	2	
Build up		2	1		1	2		
Wear resistance		2	1		1	2		
Electrical copper bus bars				1				2
Gear teeth		2	1		1	2		
Tin-bronze		1	2		2	1		
Thin sheet metal	1	2						1
Propellers		2	1		1	2		
Bronze pump casings		2	1		1	2		
Turbine build up		2	1		1			
Guides			1		1			
Valve seats		2	1		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.

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