

INCO-WELD® C656 Silicon Bronze is a copper-silicon-manganese alloy. It is particularly suited for metal inert-gas and tungsten inert-gas welding of copper-silicon alloys and for plain and galvanized sheet metal applications. It may also be used for oxyacetylene welding of other copper alloys .

*Typical Chemical Analysis (%)

Element	%
Copper (Cu)	95.9
Zinc (Zn)	0.02
Tin (Sn)	0.01
Phosphorus (P)	0.01
Lead (Pb)	0.01
Nickel (Ni)	0.01
Iron (Fe)	<0.01
Manganese (Mn)	0.99
Silicon (Si)	3.00
Aluminum (Al)	<0.01

*Typical Mechanical Properties

Tensile Strength	50,000 psi
Yield Strength	up to 25,000 psi
Elongation in 2"	52-55%
Hardness Of Weld (Brinell)	80-100

*Typical GMAW welding Parameters

Wire Diameter	Amperage	Voltage	Shielding
.030"	140	22	100% Argon or 75% Argon, 25% Helium
.035"	165	24	100% Argon or 75% Argon, 25% Helium
.045"	205	26-27	100% Argon or 75% Argon, 25% Helium
.062"	270	27-28	100% Argon or 75% Argon, 25% Helium

Approvals

AWS A5.7 RCuSi-A
SFA 5.7 RCuSi-A

Available Sizes and Packaging

GTAW		GMAW	
Diameter	Packaging	Diameter	Packaging
		.023	30 lb. Spools
1/16	10 lb. Tubes in 36" Lengths	0.30	Precision wound on 30 lb. Spools
3/32		.035	
1/8		.045	
		1/16	

*All information listed is provided as typical values and may differ from actual results due to variations in weld procedures.
IAI disclaims any liability resulting from reliance on any of the above values.

Controlled Products Group

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