

# ARCTEC® 656 Si-Bronze

Conforms to: AWS A5.7/ASME SFA6.7 ERCuSi-A



a quality welding alloy

## GENERAL CHARACTERISTICS:

ARCTEC® 656 Si-Bronze is an all position silicon bronze welding wire for use with the GMAW welding process.

## APPLICATIONS:

ARCTEC® 656 Si-Bronze is used to weld base metals of steels and cast iron to copper, brass and bronze. May also be used to weld on galvanized steels.

## MECHANICAL PROPERTIES: (Typical)

Shielding Gas Argon	Tensile Strength 50000 psi 345 Mpa	Hardness 80-100 HB	Solidus 1780 <sup>0</sup> F / 971 <sup>0</sup> C	Liquidus 1880 <sup>0</sup> F / 1027 <sup>0</sup> C
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## CHEMICAL COMPOSITION: (Undiluted)

Sn 1.00 max	Al .01 max.	Si 2.8-4.0 max	Pb .02 max.	Zn 1.0 max	Mn 1.50 max.	Fe .50 max.	Others .50 max.	Cu Balance
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## OPERATING PARAMETERS:

WELDING PROCESS: GMAW

POLARITY: DC Reverse

TRANSFER TYPE: Spray Transfer

Operating Range					
Diameter	Gas	Flow Rate	Wire Feed Speed	Amps	Volts
.030"	Argon	25 CFH	460-500 IPM	130-150	21-23
.035"	Argon	30 CFH	400-440 IPM	145-185	23.25
.045"	Argon	30 CFH	280-310 IPM	195-215	26-28
1/16"	Argon	40 CFH	150-210 IPM	260-280	27-30

## STANDARD SIZE AND PACKAGING:

Size	12" spools
.030" .80mm	13.6 kg
.035" .90mm	13.6 Kg
.045" 1.2mm	13.6 Kg
1/16" 1.6mm	13.6 Kg

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