



# ALLOY

CB-9200

AC - DC tin bronze electrode/Rod/wire  
can be used as an electric  
brazing rod

- Bronze electrode that works very well on AC current.
- Excellent for joining copper base alloys not only to themselves but to stainless steel, cast iron, and steels.

## APPLICATIONS:

For joining a wide variety of copper base alloys to themselves and to steels and cast irons.

## MICROSTRUCTURE:

A multi phase copper base structure with complex eutectoids.

## ALL WELD METAL ANALYSIS (Typical Weight %):

Sn	Fe	P	Al	Mn	Si	Ni	Cu
8	.1	.1	.001	.01	.05	.05	bal

**FLUX COLOR:** Dark Brown



#### TYPICAL MECHANICAL PROPERTIES:

##### Undiluted Weld Metal

##### Maximum Value Up to:

Tensile Strength

65,000 PSI (340 N/mm<sup>2</sup>)

Yield Strength

30,000 PSI (210 N/mm<sup>2</sup>)

Elongation

42

%

Hardness Brinell

105, Rockwell B78

**RECOMMENDED CURRENT:** DC Straight (-) or AC

#### RECOMMENDED AMPERAGE SETTINGS:

Diameter (mm)	3/32 (2.5)	1/8(3.25)	5/32 (4.0)
Minimum Amperage	75	100	120
Maximum Amperage	105	135	160

**WELDING POSITIONS:** Flat

#### DEPOSITION RATES:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Setting
3/32 (2.5)	14" (350)	.6oz (17g)	27 (59)	54 (118)	85
1/8 (3.25)	14" (350)	.7oz (20g)	22 (48)	38 (83)	120
5/32 (4.0)	14" (350)	1oz (28g)	15 (32)	20 (45)	140

#### WELDING TECHNIQUES:

Remove all surface contamination from weld area. Maintain a short arc gap and fill in craters prior to extinguishing the arc.



## ALLOY CB 9200 M (MIG)

### Recommended Welding Parameters:

	Wire Diameter	Voltage*	Amperage*
GMAW (DCRP – Electrode +)	0.035"	20-26	100-200
100% Argon or a 75 – 25%	0.045"	22-28	100-250
Argon / Helium mixture	1/16"	29-32	250-400
.	3/32"	32-34	350-500
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GTAW (DCSP – Electrode -)	1/16"	70-120	70-150
ACHF using 100% Ar or He	3/32"	120-160	140-230
2% Thoriated, 2% Ceriated or	1/8"	170-230	225-320
2% Lanthanum Tungsten Electrode	5/32"	220-280	175-300
.	3/16"	280-330	200-320

\*Use low range for iron or nickel-based alloy's, middle range for bronze alloys and high range for copper.