

TECHNICAL DATA SHEET



COPPER ALLOY

Description :

High strength flux-coated rod with low silver content for brazing ferrous metals and copper alloys together or as dissimilar assemblies.

Characteristics :

- **Excellent fluidity**
- May replace silver alloys in certain applications
- Good adherence to cast irons, copper alloys, stainless steels and alloy steels
- Deposits suitable to plating

Mechanical properties :

- Tensile strength : 100 000 psi (689 MPa)
- Elongation : up to 25%
- Bonding temperature : 750°C (1400°F)
- Hardness : 200 BH

Procedure :

Clean the section to be brazed. Gouge the thick sections and preheat the joint. Heat to obtain a liquid flux. Melt filler metal until it flows and bonds easily with the base metal. Cool slowly. Use a neutral flame.

- + **Diameter**
- + **Neutral flame**

2.5 mm

3.2 mm

Applications :

Dissimilar assemblies. Recommended for the repair of tempered steel parts, tools, molds (tool steel), extending drill bits, bearings, fittings, vices, bushings, etc. Do not use on aluminum and/or magnesium alloys.

1 800 361 9097

