

Key Facts

- Premium flux coated nickel bronze brazing wire
- Higher strengths brazing of steel and cast irons
- Excellent hardness and wear resistance

Description

Pink self fluxing filler rod for high strength braze welding of steel & cast iron mild steel.

Nickel Silver is a low fuming, cadmium free bronze. A premium quality bronze rod for maximum bond strength in braze welds on steel and cast iron and has excellent hardness and wear resisting properties. It is also excellent for fusion welding of copper-zinc alloys of similar composition and for brazing of nickel and nickel based alloys where high temperature is acceptable.

Classification, Approvals & Conformances

AWS A5.8 RBCuZn-D
ASME SFA5.8 Class RBCuZn-D

Welding Positions

H, V

Applications

Recommended for braze welding of steel, iron and cast iron. Also suitable for fusion welding of copper-zinc alloys. Its versatility lends this rod to being an excellent maintenance alloy. Also useful to build up worn surfaces of bearings, shaft, valves seats and gear teeth due to its work hardening characteristics.

Brazing or oxyacetylene welding of steel or cast iron where good color match is desired. Building-up or overlaying worn parts such as gear teeth, bearings and valve seats. Versatile maintenance repair brazing wire

Preheating may be desired for some applications. A neutral or slightly oxidizing flame is recommended.

Typical Analysis/Composition

Pb - Lead	Si - Silicon	Cu - Copper	P - Phosphorus
> 0.06	0.04 – 0.25	46.0 – 50.0	> 0.25
Ni - Nickel	Al - Aluminum	Others	Zn - Zinc
9.0 – 11.0	> 0.01	> 0.50	Balance

Typical Weld Mechanical Properties

Tensile Strength:	> 400N/mm ²
Elongation (5xD):	25%

Packaging & Ordering Information

Size	Weight	Part Number
2.4mm	1kg	300108H
2.4mm	5kg	300108
3.2mm	1kg	300109H
3.2mm	5kg	300109