

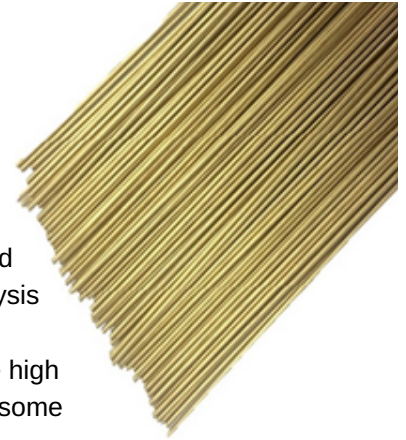
C 68100 Brass Brazing Wire

C68100 LOW FUMING BRONZE BRAZING ALLOY

AWS A5.8: RB CuZn-C / UNS: C68100 / EN ISO 1044: CU 304 |

DIN: W. Nr. 2.0533 / DIN: L-CuZn39Sn

Low Fuming Bronze C68100 suitable for welding of copper material, such as copper and tin copper alloys, especially for jointing welding of copper-zinc and steel. Also used for repairing of copper cast parts. Low Fuming Bronze is a general-purpose oxyacetylene brazing rod used for steel, copper alloys, cast iron, nickel alloys and stainless steel. A balanced chemical analysis of copper and zinc as well as alloying elements of tin, iron, manganese and silicon produce weld deposits are easily attained simply by applying a neutral or slightly oxidizing flame. The high silicon content of Low Fuming Bronze keeps fumes to a minimum. Preheating is required for some applications and bronze brazing flux is required for the bare rods.



TYPICAL APPLICATIONS:

Industrial welding for cast iron, gas welding and carbon arc welding of brass, Braze welding of copper, steel and cast iron, good fluidity, Exhalation-resistance of zinc. Also use in gas welding of copper, steel, copper-nickel, cast iron and cemented carbide alloy tools incrustation.

CHEMICAL COMPOSITION:

	Cu	Pb	Sn	Zn	Fe	Al	Mn	Si
Min (%)	56.0-60.0	0.05 Max	0.75-1.10	Rem	0.25-1.25	0.01 Max	0.01-0.50	0.04-0.15
Max (%)								

PHYSICAL AND MECHANICAL PROPERTIES:

UTS kg/mm ²	46 Min.
Elongation on 5.65 50 / 50 mm	8 Min.
Hardness (HRB/ HB / HV)	130 Min
Solidus Temperature	866°C (1591°F)
Density	8.4 gms/cm ³
Liquidus Temperature	888°C (1630°F)

SIZES AVAILABLE:

Wire	1.0 mm to 11 mm Max
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