

**DESCRIPTION**

**High strength** flux-coated rod for brazing, hardfacing and **building up in multiple passes** of ferrous and non-ferrous metals.

**CHARACTERISTICS**

- **Very good impact and corrosion resistance**
- Very low friction coefficient
- Excellent chip-free machinability
- Ductile and porosity-free deposits
- Work hardening deposit
- Good adherence on steels, cast irons, copper alloys, stainless steels, alloy steels and nickel alloys

**TYPICAL APPLICATIONS**

Building up of missing, used or broken parts. Gear teeth, gears, guide rails, shafts, bearings, key way, pulleys, etc.

**PROCEDURE**

Clean the brazing area. Chamfer heavy parts and preheat the joint. Melt the flux from the end of the rod until it becomes fluid. Melt the filler metal to adhere easier to the base metal. Allow to cool down slowly. Use a neutral flame.

**MECHANICAL PROPERTIES**

Tensile strength: 85 000 psi (586 MPa)  
 Elongation: 22 %  
 Hardness (as-welded): 130 BH      Work hardened: 210 BH

**BRAZING PARAMETERS**

Diameter: 3.2 mm (1/8")      2.5 mm (3/32")  
 Bonding temperature: 760°C (1400°F)  
 Type of flame: Neutral

Rév.: 7\_01

*Specialized welding alloys and technology. For technical assistance or for ordering:*