WELDWIRE COMPANY, INC.  Technical Information

Brazing Rod

Alloy: WWLFB Coated  Certification: AWS A5.8
Class: RBCuZn-C  ASME SFA A 5.8

Alloy: LFB Bare (Low Fuming Bronze)
Weld Process: Brazing Rod

AWS Chemical Composition Requirements
Cu = 56.0 – 60.0  Al = 0.01 max
Sn = 0.80 – 1.10  Si = 0.04 – 0.15
Zn = Balance  Pb = 0.05 max
Fe = 0.25 – 1.20  Mn = 0.01 – 0.50
Other = 0.50 max

Recommended Operation of Brazing Rods
Clean all areas to be joined or built-up thoroughly. Paint weld are with Welco 600 bronze brazing flux. Using a neutral flame, heat the part until the flux liquefies. The flux can also be applied directly to the rod, by heating the rod and dipping into the powdered flux. Add a drop of the alloy and flow it out using the torch flame. If a large area is to be surfaced or a number of passes are required to restore the part to the original size, Nickel Silver flux coated rods should be used. There is no need to remove the flux between passes. The torch should be held at a low angle to prevent excessive heat build-up in the part. When working on cast iron, bonding qualities can be improved by first searing the surface with a strong oxidizing flame.

Application
Designed for repair and fabrication application on steel copper, copper alloys, nickel, and nickel alloys.

If additional information is needed Contact Weldwire Company, Inc. 800-523-1266