

Brazing Rod

Alloy: WWLFB Coated
Class: RBCuZn-C

Certification: AWS A5.8
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.

Deposited All Weld Metal Properties %
(Typical) As-Welded

Not Specified in AWS Specification

Application

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

Deposited Charpy-V-Notch Impact Properties %
(Typical) As-Welded

Not Specified in AWS Specification

