Key Facts

- Low fuming, flux coated general purpose bronze filler rod
- Ductile weld metal
- Good mechanical properties
- Excellent maintenance wire

Description

Low fuming, general purpose bronze filler rod for braze welding of bronze, cast iron steel and malleable iron. Manganese bronze is the ideal maintenance rod due to its versatility and good mechanical properties. Its high bond strength makes it suitable for use in a wide range of self-fluxing applications.

Excellent choice for rush jobs or temporary applications involving dissimilar metals or where rust is present. Galvanized parts can be brazed without causing damage to the zinc coating. Best for color matches on yellow brass and bronze castings.

Applications

Used extensively for gas brazing steel, copper alloys, cast iron, nickel alloys and stainless steel. The weld deposits are non-porous for leak proof joints for water, oil and gas lines. The weld deposit freezes rapidly from fluid to a plastic state. Preheat is required for some applications and a brazing flux is recommended.

Clean joint area as thoroughly as possible. Bevel cracks or heavy sections. Utilize a slightly oxidizing flame; preheat the part to be brazed. If using bare LFB, dip it into the bronze brazing flux and then back to the area brazed. Apply the torch, keeping it in constant motion to avoid overheating a particular area of the base metal.

- Excellent maintenance wire
- Suitable for steel, stainless steel, copper and nickle alloys

Welding Positions

H, V

Classification, Approvals & Conformances

AWS A5.8 RBCuZn-c
UNS C68100, ASME SFA 5.8

Typical Analysis/Composition

Pb - Lead	Mn - Manganese	Zn - Zinc	P - Phosphorus
<.0.06	4.5 – 5.5	Balance	<.0.05
Ni - Nickel	**Ai - Aluminum**	**Cu - Copper**	**Sn - Tin**
< 0.01	< 0.001	5.5 - 57	21 - 23
Fe - Iron			
15 - 19			

Typical Weld Mechanical Properties

Yield Strength:	71 ksi
Tensile Strength:	> 400N/mm^2
Elongation (5xD):	25%

Packaging & Ordering Information

Size	Weight	Part Number
1.6mm	1kg	300095H
1.6mm	5kg	300095
2.4mm	1kg	300096H
2.4mm	5kg	300096
3.2mm	1kg	300097H
3.2mm	5kg	300097
5.0mm	1kg	300098H
5.0mm	5kg	300098

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.