Key Facts

- Premium bare nickel bronze brazing wire
- Higher strengths brazing of steel and cast Irons
- Excellent hardness and wear resistance

Description

Nickel Silver is a low fuming, cadmium free bronze. A premium quality bronze rod for maximum bond strength in braze welds on steel and cast iron and has excellent hardness and wear resisting properties. It is also excellent for fusion welding of copper-zinc alloys of similar composition and for brazing of nickel and nickel based alloys where high temperature is acceptable.

Classification, Approvals & Conformances

AWS A5.8 RBCuZn-D
ASME SFA5.8 Class RBCuZn-D

Welding Positions

H, V

Applications

Recommended for braze welding of steel, iron and cast iron. Also suitable for fusion welding of copper-zinc alloys. Its versatility lends this rod to being an excellent maintenance alloy. Also useful to build up worn surfaces of bearings, shaft, valves seats and gear teeth due to its work hardening characteristics.

Brazing or oxyacetylene welding of steel or cast iron where good color match is desired. Building-up or overlaying worn parts such as gear teeth, bearings and valve seats. Versatile maintenance repair brazing wire

Preheating may be desired for some applications. A neutral or slightly oxidizing flame is recommended.

Typical Analysis/Composition

Pb - Lead	Si - Silicon	Cu - Copper	P - Phosphorus
> 0.06	0.04 – 0.25	46.0 – 50.0	> 0.25
Ni - Nickel	**Ai - Aluminum**	**Others**	**Zn - Zinc**
9.0 – 11.0	> 0.01	> 0.50	Balance

Typical Weld Mechanical Properties

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

Packaging & Ordering Information

Size	Weight	Part Number
1.6mm	1kg	300089H
1.6mm	5kg	300089
2.4mm	1kg	300090H
2.4mm	5kg	300090
3.2mm	1kg	300091H
3.2mm	5kg	300091

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.