



Av. Guillermo Dansey 2050, Lima 01, Perú.

T: (51-1) 336-8601 / (51-1) 336-8602. F: (51-1) 336-7141.

ventas@tecnoweld.com.pe www.tecnoweld.com.pe

TB-60B

Specially formulated low-fuming copper-zinc alloy with the additions of nickel, manganese and iron to improve flow and increase strength. Zinc is adjusted to limit zinc fuming and increase flow. Applied on steels, copper, nickel and stainless steel.



APPLICATIONS:

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CHARACTERISTICS:

Melting Range	: Solidus 890°C / Liquidus 900°C
Working Temperature	: 910 - 960°C
Heating Method	: Torch, Furnace, Induction
Tensile Strength	: 45 kg/mm ² (64000 psi)
Elongation in 2"	: 30%
Chemical Composition	: Cu 58%, Zn 39%, Sn 1%, Mn 0.25%, Fe 0.5%

PROCEDURE:

Clean brazing area. Bevel sections thicker than 4.00 mm. For cast iron, burn the brazing area with an oxidizing flame until it becomes blue. Preheat thick parts to 400°C using a neutral flame. Apply a small amount of flux on the joint until it liquefies and melt a drop of alloy on the base metal. Continue this procedure until the operation is completed. Allow to cool slowly and remove all flux residue.

AVAILABLE FORMS:

Round rods (Ø)	: 1/16" (1.6 mm), 3/32" (2.4 mm), 1/8" (3.2 mm), 5/32" (4.0 mm), 3/16" (4.8 mm), 1/4" (6.3 mm) and other Ø upon request
Lengths	: 500mm or 36" (914mm)