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-85
(AWS RBCuZn-D)

Nickel brass brazing alloy resistant against frictional wear.

APPLICATIONS:

Used for all kinds of steel, cast iron, copper, nickel and nickel alloy applications. Ideal to rebuild broken gear teeth, worn bearings, cams, valve seats, pistons, chain links, shafts, and to rebuild pump impellers. Also used to weld galvanized steel parts, reducing the zinc layer. Used to join tungsten carbide parts to high-strength steel bases. This work-hardening alloy is very resistant and is therefore ideal as a surface coating that requires great resistance against frictional wear. It is also highly resistant to corrosion.

CHARACTERISTICS:

Melting Range	:	Solidus 921°C / Liquidus 935°C
Working Temperature	:	938-982°C
Heating Method	:	Torch (neutral flame), Furnace, Induction
Nozzle resistance	:	5 mm for weld seaming
Tensile Strength	:	60 kg/mm² (85300 psi)
Elongation in 2”	:	25%
Hardness	:	130 HB (as deposited) and 200 HB (work hardened)
Chemical Composition	:	Cu 48%, Zn 41.9%, Ni 10%, Si 0.1%

PROCEDURE:

Clean brazing area removing rust or grease. Bevel thick sections or cracks. Use a neutral flame and hold the torch at a low angle to the base metal. Heat until it becomes a dull red color. Rub a little flux at the start of the brazing area, or use flux if bare rods are used. When the flux is flowing freely deposit a drop of alloy and pass the flame over it until it melts and joins easily. Add the alloy until the desired shape and size are obtained. Layer after layer can be deposited without removing the flux or previously cleaning the deposit.

AVAILABLE FORMS:

Round rods (Ø):	:	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
Length	:	500mm