TB-60

Description:

- General purpose brass brazing alloy with excellent fluidity.

Applications:

- Used for brazing steels, cast iron, copper, bronze, brass and nickel.
- Suitable for locksmithing, manufacturing and repairing of metal bodyworks, pipe joints and galvanized sheets, manufacturing and repairing of hydraulic equipment, and for ornaments, jewelry, etc.
- Specially formulated to include tin which offers better mechanical properties and good corrosion resistance. It can be used to make weld seams or when fine flow is required.

Characteristics:

Melting Range	Solidus 890°C / Liquidus 900°C
Working Temperature	910 - 960°C
Heating Method	Torch, furnace, induction
Tensile Strength	45 kg/mm² (64,000 psi)
Elongation in 2"	30%
Chemical Composition	Cu 60%, Zn 39.7%, Si 0.3%

Procedure:

1. Clean brazing area. Bevel sections thicker than 4.00 mm.
2. For cast iron, burn the brazing area with an oxidizing flame until it becomes blue.
3. Preheat thick parts to 400°C using a neutral flame.
4. Apply a small amount of flux on the joint until it liquefies and melt a drop of alloy on the base metal.
5. Continue this procedure until the operation is completed.
6. 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)
Lengths	500 mm or 36" (914 mm)

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