

TB-85

Description:

- Nickel brass brazing alloy resistant against frictional wear

Applications:

- Used for brazing steels, cast iron, copper, bronze, brass and nickel.
- 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	935 - 982°C
Heating Method	Torch, furnace, induction
Tensile Strength	60 kg/mm ² (85,300 psi)
Elongation in 2"	25%
Chemical Composition	Cu 48%, Zn 41.9%, Ni 10%, Si 0.1%

Procedure:

1. Clean brazing area. Bevel sections thicker than 4.00 mm.
2. Use a neutral flame and hold the torch at a low angle to the base metal. Heat until it becomes a dull red color.
3. 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.
4. Add the alloy until the desired shape and size are obtained.
5. Layer after layer can be deposited without removing the flux or previously cleaning the deposit.

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)

