Tradeflame

BRAZING & WELDING ROD COMPARISON CHART

Part No.	Material	Colour	Composition	Tensile Strength	Working Temperature	Melting Range	Material Compatibility	Projects
211556	Nickel Bronze	Pink	RBCuZn-D	515 MPa 75,000 psi	940°C - 980°C 1724°F - 1796°F	921°C - 935°C 1689°F - 1715°F	Joining metals: stainless steel, cast iron, nickel, brass alloys	Metal components: Gear teeth, fences, radiators.
211567	Aluminium	Silver		200 MPa 29,000 psi	574°C - 632°C 1065°F - 1170°F			Soldering aluminium windows, doors, joints, aluminium boats, gutters , aluminium motor castings and zinc based castings
211578	Bronze	Blue	RBCuZn-C	415 MPa 60,000 psi	910°C - 955°C 1670°F - 1751°F	866°C - 888°C 1590°F - 1630°F	Steel, cast iron, copper based, galvanized and malleable metals	Weld deposits are non-porous for leak proof joints on water, oil and gas lines. Weld deposits freeze rapidly from a fluid to solid state
228434	Nickel Bronze	Pink	RBCuZn-D	515 MPa 75,000 psi	940°C - 980°C 1724°F - 1796°F	921°C - 935°C 1689°F - 1715°F	Joining metals: stainless steel, cast iron, nickel, brass alloys	Metal components: Gear teeth, fences, radiators.
228445	Bronze Flux	White	RBCuZn-A	400 MPa 58,000 psi	900°C 1652°F	875°C - 890°C 1607°F - 1634°F	Selected beams, bronzes and low strength brazing of steel	For gas welding only. Brazing of brass and bronze. Braze welding of copper and alloys.
228456	Manganese Bronze	Blue	RBZuZn-C	415 MPa 60,000 psi	910°C - 955°C 1670°F - 1751°F	866°C - 888°C 1590°F - 1630°F	Steel, cast iron, copper based, galvanized and malleable metals	For gas welding only. Not recommended for the joining of copper pipes which carry hot water or sea water
228467	Silver	Silver	Copper with 5% silver	250 MPa 36,000 psi	710°C - 820°C 1310°F - 1508°F	645°C - 815°C 1193°F - 1499°F	Brazing of copper and copper alloys, silver and molybdenum	For gas welding only. Suitable for silver brazing of copper pipes used in general plumbing applications. Requires the use of Silver Flux Paste 228478

INSTRUCTIONS FOR BRAZING

1. Thoroughly clean all areas to be joined with sand paper.
2. A slight oxidising flame should be used to braze. Adjust your flame accordingly.
3. Heat the edges to be joined to a dull red colour. Melt the end of the flux coated rod and at the same time heat both ends of the area being brazed to an equal amount. Ensure that the tinning has occurred on the area being brazed.
4. Melting of the area being brazed is not required in brazing and care should be taken not to overheat the base metal.
5. Continue adding the filler rod to the base metal until the required size and shape is attained.
6. Allow the joint to cool, remove any flux residue with a wire brush or acid solution followed by a water rinse.