



BRACS 3344

Coated Brazing Rods

ALLOY BASIS :

Ag, Cu, Zn, Cd, Additives

KEY FEATURES:

- Flux coated brazing rod
- High silver content
- Lowest melting point
- Excellent flowing characteristics
- Excellent capillary action
- Strong, clean and smooth joints

TYPICAL APPLICATIONS:

- Brazing of CuZn20Al, CuNi10Fe, CuNi30Fe
- Capillary brazing on steels and stainless steels, malleable cast iron, copper and copper alloys, nickel, nickel alloys and hard metals and their dissimilar combinations
- Construction of apparatus, shipbuilding, precision tools, copper conductor joints
- Refrigeration plants, electrical industry, fittings manufacture, installation works, furniture, carbide tip brazing, drill bits brazing



HEAT SOURCE: Oxy-acetylene torch, Air-gas torch, Blow-lamp, Furnace, High frequency induction

PROCEDURE :

Clean the joint thoroughly. Use neutral flame. Joint clearance approx. 0.1 mm. Preheat a broad area and then heat locally until flux melts. Melt filler metal and draw with flame along the joint. Do not overheat.

CLEANING:

Remove Flux residues by rinsing in hot water.

TECHNICAL DATA :

Solidus Temperature	Liquidus Temperature
615°C	620°C

PACKING DATA:

Ø x L, mm	Kg/Plastic Tube
2.50 x 500	2
3.15 x 500	2