



BRAS 3356

Bare Brazing Rods

ALLOY BASIS :

Ag, Cu, Zn, Sn

KEY FEATURES:

- Cadmium free brazing filler rod
- High Silver content of 56%
- Excellent flowing characteristics and capillary action

TYPICAL APPLICATIONS:

- Joining of steels, Stainless steels
- Malleable iron, Dissimilar steels
- Copper, Brass, Bronze, Nickel
- Recommended for joints in contact with food e.g. Dairies, Breweries, Canned food industries



HEAT SOURCE: Oxy-Acetylene torch, Air-Gas torch, Blow lamp, Furnace

PROCEDURE :

Clean the joint thoroughly. Use neutral flame. Spread the flux in paste form on the joint. Dip heated rod into flux. Joint clearance should be approximately 0.1 mm. Preheat a broad area and then heat locally until flux melts. Continue heating joint area until the flux melts. Melt filler metal and draw with flame along the joint. Do not over heat.

CLEANING:

Remove Flux residues by rinsing in hot water.

TECHNICAL DATA :

Solidus Temperature	Liquidus Temperature	Brazing Temperature Range
618°C	652°C	650-760°C

PACKING DATA:

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