



Pipe Joints

## Flux coated brazing rod suitable for joining of dissimilar steel to Cu alloy including Ni enhanced high strength bronzes

### Typical Applications:

Tubular chassis, frames, drills and cutters, carbide tipping, piping, keys, composite tools and dies, steel furniture.

Remove flux residues by washing with water. Use EWAC BR 516 flux for supplementary requirements.

### Outstanding Features:

- Durable and flexible flux coating.
- No smoke, fumes; clear visibility of molten pool.
- Superior wettability and bonding.
- Excellent capillary action.
- Thin flowing.

### Size:

Size (mm)
2.5
3.15

**Bonding Temperature:** 875°C

**Tensiles Strength:** 700 MPa (1,00,000 psi)

### Procedure:

Clean and degrease joint areas. Bevel heavy section. Preheat parts. Melt off drop of flux from end of rod on beginning of joint area. Continue heating until flux liquefies. Deposit alloy drop by drop, feeding into flame as required, making sure each drop bonds properly. Air cool.