

Wire type:

OAW Solid wire

Welding positions:



Shielding gas:

Oxy-acetylene

Bronze C is our low fuming bronze (brass) brazing rod for joining and surfacing steel, copper and copper alloys, brass, grey and malleable cast iron, nickel and nickel alloys. Bronze C produces poreless joints, colour matching with brass. Applications are universal but typical for joining galvanized steel (without destroying its zinc layer), joining non-ferrous metals, tube structures, sanitary installations, fitting and repair work, bicycles, motorcycles, automotive industries, furniture industry. The Mn content guarantees strong and high quality joints.

Base materials to be welded:

- Similar and dissimilar joining
- To be used in combination with HILCO Bronze Flux.

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Repair & Maintenance
- Transport & Lifting Industry
- Process Industry

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	-	-	-	-	Bronze F

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	S	P	Ni	Sn	Fe	Cu	Ti	Zn	Al
	0,60	0,40			≤ 0,01	0,35	≤ 0,10	60,0		Bal.	≤ 0,005

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Melting range
As welded	-	≥ 490	≥ 35	870-900°C

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,5	1000	5
2,0	1000	5
2,5	1000	5
3,0	1000	5
4,0	1000	5
5,0	1000	5