Coated Brazing Rods

BRACC 2211

FLUX COATED SPECIAL BRASS BRAZING ALLOY

ALLOY BASIS :

Cu, Zn, Additives

KEY FEATURES :

- Flux coated brazing rod
- Provide excellent wetting action
- No objectionable fuming
- Good machinability
- Very fast and economical operation
- Applied with a high quality coating to speed up brazing
- Flexible and thin flux coating does not peel off even after bending
- Flux coating has extended life span

TYPICAL APPLICATIONS :

- Brazing of steel, cast iron, copper, brass
- Galvanized iron
- Joins dissimilar metals like steel to cast iron, steel to copper and copper alloys, cast iron to copper and copper alloys
- Excellent for sheet metal assembly and repair
- Repair of car bodies and car silencer assembly in overhead position without dismantling

HEAT SOURCE :

Oxy-acetylene torch, Furnace, High frequency induction

PROCEDURE :

Clean the joint thoroughly. Use neutral flame. Preheat a broad area and then heat locally until flux melts. Then apply filler rod and melt it into the joint. For braze-welding, melt the rod drop by drop along the joint. For capillary joints melt the rod and draw with the flame along the joint. In case of cast iron, preheat the entire casting to 450°C and maintain this preheat until the operation is completed. In using Bracc 2211 melt the flux from the end of rod on the start of the weld area. Continue heating the weld area until the flux melts. Next melt a drop of filler metal by playing the flame on the rod end until it flows and bonds easily. Continue adding more of the filler metal drop by drop into the joint

CLEANING :

Remove flux residues mechanically or chemically (using 10% hydrochloric acid for ferrous metals and 10% sulphuric acid for copper and its alloys) followed by rinsing in running water.

TECHNICAL DATA :

Solidus Temperature	Liquidus Temperature	Brazing Temperature Range
888°C	899°C	910-954°C

PACKING DATA :

Ø x L, mm	Kg/Plastic Tube
2.50 x 500	5
3.15 x 500	5

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