



Coated Brazing Rods
BRACC 7700

FLUX COATED SPECIAL BRONZE ALLOY FOR WEAR RESISTANCE



ALLOY BASIS :

Cu, Zn, Ni, Additives

KEY FEATURES :

- Flux coated rod
- Can be used directly on the job
- No external flux required
- Very fast and economical operation
- Tough and easily machinable alloy
- Deposit is free from porosity with resistance to corrosion and wear
- Flexible and thin flux coating does not peel off even after bending
- Flux coating has extended life span

TYPICAL APPLICATIONS :

- Surfacing of steel, grey cast iron, bronze
- Especially suitable for wear resistant surfacing
- Gear teeth, Bevel gear tracks, Shafts, Cams, Slide bars
- Bearings, Metal seals, Valve seats, Pistons



HEAT SOURCE :

Oxy-acetylene torch

PROCEDURE :

Clean the joint area. Prepare the edges especially for heavy section and cracked area. Preheat the job and melt off a drop of flux from the end of the rod onto the beginning of the joint area. Continue heating until flux liquefies and add the filler metal drop by drop making sure of a good bond.

TECHNICAL DATA :

Working temperature	Hardness of pure deposit, HRC
900°C	10-15

PACKING DATA :

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