



BRAS 3302

Bare Brazing Rods

ALLOY BASIS :

Cu, Ag, P

KEY FEATURES:

- Cu-P brazing filler rod with Silver
- Very good gap filling properties
- Suitable for bridging broad gaps
- No flux is required for copper to copper brazing

TYPICAL APPLICATIONS:

- Construction of pipes and apparatus
- Refrigeration industries
- Brazing of Cu-Zn, Cu-Sn alloys in then construction of apparatus, nelectric motors
- In breweries, dairies and shop fittings



HEAT SOURCE: Oxy-acetylene torch, Air-gas torch, Blow lamp

PROCEDURE :

Ensure parts to be welded are thoroughly cleaned. Adjust flame to neutral. For copper, heat parts to be joined to dull red and for copper alloy, heat until flux liquefies. Melt small amount of filler allow to flow along joint while removing flame. To avoid overheating use intermediate position in the flame, to give general heat. Do not use intense heat at top of the inner cone. Immersion in dilute sulphuric acid solution followed by water rinse will restore copper colour of the brazed area.

CLEANING:

Remove Flux residues by rising in hot water.

TECHNICAL DATA :

Solidus Temperature	Liquidus Temperature	Brazing Temperature Range
643°C	788°C	730-815°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