



Tube to Tube Sheet Joining

Torch brazing rod for self-fluxing copper-to-copper joints

Typical Applications:

Electric motor repairs, armatures, air conditioning and refrigeration tubing.

Outstanding Features:

- Low melting brazing alloy.
- Strong, ductile, leak-proof joints.
- Silver-bearing; thin flowing.
- Good corrosion resistance.
- Self fluxing for copper to copper brazing.

Recommendation:

For production brazing of lap, flange and 'T' joints of copper, brass & bronze metals. The alloy displays good capillary properties, to enable satisfactory flow & penetration even in narrow corners or areas. The alloy is 'self-fluxing' for Cu-to-Cu joints. Use of EWAC BR 604 flux is recommended for brazing of copper alloys such as brass or bronze. This alloy is not recommended for brazing of ferrous or nickel alloys.

Procedure:

Clean the surface. Jigs or fixtures are recommended for good fit and proper clearance. Flux is not required for Cu-to-Cu brazing. For brazing of copper based alloys (ie., brass or bronze). Use EWAC BR 604 flux. Heat the entire assembly evenly, until copper turns dull red in colour or the flux, if used, liquefies. At this stage, melt off a drop of alloy from the rod and flow it into the joint. Repeat this, until the joint is completed.

Recommended Amperages:

Size (mm)
1.6
3.15

Bonding Temperature: 640°C

Tensile Strength: 35 Kg/mm² (50,000 psi)