

2080

SUPER STRONG GENERAL PURPOSE BRAZING ROD WITH PRECISION FLUX CONTROL

GENERAL CHARACTERISTICS

Premium alloy for general maintenance repair with an Oxy /Fuel Torch. With the unique concentrated flux imbedded in the surface of the brazing rod, the welder will no longer have to fight through excessive flux to put down a perfectly brazed joint. At 1400°-1600°F the deposit has controlled fluidity which makes it ideal for surfacing and build-up of parts subjected to frictional wear. When the temperature is increased to 1650° - 1750°F the alloy becomes very thin flowing and will produce high strength joints with only .001" to .003" clearance. The P.F.C. (Precision Flux Controlled) will in most instances cut brazing and clean up time in half. These are extremely important factors when dealing with cost conscious welders or companies.

APPLICATIONS:

1. Low temperature- overlaying and build-up of gear teeth, bearings, shafts, valve seats, wedge bars and steering knuckles.
2. High temperature- for close fitting joints on broken drills, mill cutters, furniture and bicycle assemblies, attaching carbide cutting tips and many other applications requiring high strengths. This alloy is designed to build-up and join carbon steels, alloy steels, cast iron and many nonferrous materials to themselves or multiple combinations.

TECHNICAL DATA:

Tensile Strength.....	up to 113,800 psi (80 kg/mm ²)
Hardness(HB)	140-200
Working Temperature	1250°-1750°F (760°-955°C)
Remelt Temperature	approx. 1800° F (980°C)
Diameter (in) 1/16 3/32 1/8 3/16	
(mm) 1.6 2.4 3.2 5.0	

PROCEDURE:

Clean area to be joined or built up from any foreign matter, such as paint, grease etc. For best results rough grind the surface. Always use a neutral flame concentrated on the base metal, not on the molten alloy. Keep the torch in constant motion to prevent overheating of local areas. When used as a joining alloy, small rods are recommended, but for surfacing and build-up the larger diameter rods should be used. Allow the part to cool slowly. Remove the minute amount of flux residue by wire brushing.

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