

LFB

UNIVERSAL BRONZE ALLOY WITH FLUX COVERING. STRONG WELD TYPE. ITS COLOUR MATCHES THAT OF BRASS.

IDENTIFICATION: WHITE COATING

APPLICATIONS: To join or to cover steel, cast iron, bronze, copper, brass, mild and galvanized iron or any combination of these metals. Brass and also bronze can be welded by fusion. It is widely used in maintenance work as a strong weld alloy for general purposes. Resulting joints in brass are pore free, the base metal is not molten down and the colour is the same. In galvanized steel, this welding alloy does not damage the zinc coating. Filler metal deposits can be hammered. Ideal to weld non ferrous metals (except aluminium), for pipes, to manufacture metal furniture, sanitary facilities, car bodies, plumbing jobs, repairs, tungsten carbide inserts, drilling equipment and gouges, cams, tubular steel furniture, bicycle frames, spring leaves, pulleys, pistons, vessels for acids and for mild alkali.

CHARACTERISTICS AND PROCEDURE: The flux covering the welding rod removes rust easily. This flux allows the filler metal to wet the surface well at a lower temperature. Clean the areas to be welded. Cast iron surfaces have to be preheated with a highly oxidizing flame. Then, clean the surface with a wire brush to remove graphite and impurities. Use a neutral flame, heat the base metal and let a small amount of the rod flux to melt down. Then, allow the welding rod to start melting down onto the base metal surface. Follow this procedure till the end of the welding job. Let the part cool down slowly. If necessary, use VILCHIS BRONCIL flux to achieve extra capillary fluency. Adjacent areas can be coated with this flux to avert colour loss.

HEAT SOURCE:	OXYFUEL GAS TORCH, HIGH FREQUENCY INDUCTION OVEN.
TENSILE RESISTANCE:	4200 KG/CM2 - (60.000PSI)
ELONGATION:	26%
WORKING TEMPERATURE:	750 TO 900 °C
FLAME SETTING:	BRASS, BRONZE AND GALVANIZED STEEL.- SLIGHTLY OXIDIZING.
COPPER AND STEEL:	NEUTRAL

FILLER METAL CHEMICAL ANALYSIS %			AVAILABLE SIZES
Cu	Zn	Sn	2.4 mm - 3/32"
58.0	40.0	0.95	3.2 mm - 1/8"
			4.0 mm - 5/32"