

PRODUCT DATA SHEET

Afrox Fluxobronze M15

A general purpose flux coated bronze alloy used for bronze welding and brazing copper, cast iron, steel sheet and for light assembly work. This low fuming brass rod is fast flowing and leaves minimal flux residue. The fast flowing nature of the alloy reduces heat input which causes distortion.

Classifications

AWS	A5.27 R	CuZn-C
EN	24373	Cu4700 CuZn405n

Typical Chemical Analysis (Wire analysis)

% Copper	56,0 - 60,0	% Iron	0,25 - 1,2
% Manganese	0,01 - 0,5	% Tin	0,8 - 1,1
% Silicon	0,04 - 0,15	% Zinc	Bal.

Physical Mechanical Properties

Melting Range	860°C
Approximate Tensile Strength of Deposited Metal	440 MPa
Approximate Brinell Hardness	120 HB

Brazing/Welding Parameters

Process	Oxy-acetylene
Flame Setting	Neutral

Packing Data

Diameter (mm)	Consumable Length (mm)	Pack Mass (kg)	Item Number
2,5	450	5,0	W000375
3,2	450	5,0	W000376

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