



# CEWELD CuNi10ZnF

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                   |                                |           |                    |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------|--------------------------------|-----------|--------------------|
| TYPE                                              | CuZnNi high strength flux coated brazing alloy.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                   |                                |           |                    |
| APPLICATIONS                                      | Joining: Steels, Galvanized steel, Tempered Cast Iron, Cast iron, Nickel alloys etc. This alloy is mainly used in the furniture and the bicycle industry for high strength joining of steels, also is this alloy recommended for rebuilding cock wheels due to the good sliding properties.                                                                                                                                                                                                                                                                                                   |                                                   |                                |           |                    |
| PROPERTIES                                        | High strength brass alloy containing Nickel for more strength and bridging capability during brazing. Due to the special flux coating this type is mostly used in maintenance and repair, the flux coated rod can be bended very well without losing flux.                                                                                                                                                                                                                                                                                                                                    |                                                   |                                |           |                    |
| CLASSIFICATION                                    | AWS<br>EN ISO<br>W.Nr.<br>F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | A 5.8: RBCuZn-D<br>17672: Cu 773<br>2.0711<br>106 |                                |           |                    |
| SUITABLE FOR                                      | Steels, Galvanized steel, Tempered Cast Iron, Cast iron, Nickel alloys                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                   |                                |           |                    |
| APPROVALS                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                   |                                |           |                    |
| WELDING POSITIONS                                 |        |                                                   |                                |           |                    |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | Si<br>0.1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Ni<br>10                                          | Cu<br>48                       |           |                    |
| MECHANICAL PROPERTIES                             | Heat Treatment<br>As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | R <sub>P0,2</sub><br>(MPa)                        | R <sub>m</sub><br>(MPa)<br>800 | A5<br>(%) | Hardness<br>180 HB |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                   |                                |           |                    |
| MELTING RANGE                                     | 890 - 920°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                   |                                |           |                    |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                   |                                |           |                    |