

PRODUCT DATA SHEET

Afrox M15 Bronze

A widely used brazing and bronze welding rod depositing metal which has good tensile strength. This versatile brazing rod is ideally suited for sheet metal work such as motor bodies, tubular and galvanized iron fabrication as well as for copper and for brazing cast iron, and heavy steel sections. The product may be used for fusion-weld brass.

Classifications

AWS	A5.27 R	CuZn-C
EN	24373	Cu4700 CuZn40Sn
Rod Identification M15 - stamped		

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 and Mechanical Properties

Melting Range	860°C - 890°C
Tensile Strength	460 MPa
Approximate Brinell Hardness	125 HB

Brazing/Welding Parameters

Process	Oxy-acetylene
Flame Setting	Neutral (depending on base metal)
Flux	Use with Aprox M15 Brazing Flux (Item Number W001553) or Aprox Liquid Flux (Item Number W001555)

Packing Data

Diameter (mm)	Consumable Length (mm)	Pack Mass (kg)	Item Number
2,0	750	5,0	W000504
3,2	750	5,0	W000500
5,0	750	5,0	W000501
6,3	750	5,0	W000502

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