

PRODUCT DATA SHEET

Afrox Nickel Bronze DB



A versatile 10% nickel bronze alloy rod suitable for bronze welding and brazing of steel, cast iron and copper alloys. Since the weld deposit work hardens in service, the rod is ideal for building up worn or broken parts such as gear teeth, bearings, valve seats and faces. It is widely used for maintenance work.

Typical Chemical Analysis (All weld metal)

% Copper	46,0 - 50,0	% Lead	0,05 max
% Nickel	9,0 - 11,0	% Aluminium	0,01 min
% Silicon	0,04 - 0,25	% Zinc	Bal.
% Phosphorous	0,25 max		

Typical Mechanical Properties

Melting Range	800°C - 910°C
Tensile Strength	530 MPa
Approximate Brinell Hardness	
As Deposited	150 HB
Work Hardened	320 HB

Brazing/Welding Parameters

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

Packing Data

Diameter (mm)	Electrode Length (mm)	Pack Mass (kg)	Item Number
1,5	700	5,0	W000520
2,0	700	5,0	W000522
3,2	700	5,0	W000521

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