



BS 1453 C5
 DIN 8513 L CuNi10Zn42
 EN ISO 3677 B Cu 49 Zn Ni Si 890-920

Nickel Bearing Brazing Alloy

BA-1210

DESCRIPTION & APPLICATION

High strength, Nickel-bearing brazing alloy. Usage includes wear facing of gear teeth, overlay/joining of cast iron, etc. to give non sparking wear facing (Motor industry Draw Dies). Work hardening deposit with low coefficient of friction. Available in bare wire, or flux-coated. Melting range 920-980°C. Melting Range 870-890°C.

BASE MATERIALS

Copper Alloys, Mild and Low Alloy Steels, Cast iron, Stainless Steel.

MECHANICAL PROPERTIES

~540 UTS n/mm	N/A YIELD 0.2%	N/A ELONG A5%	>200 HARDNESS HB
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METAL WELD COMPOSITION %

Si	Zn	Mn	Cu	Ni
<1.0	BAL	Trace	49.9	9.0

PACKAGING

Diameters available: 1.5, 2.0, 2.5, 3.0mm
 Packed in 5kg Tubes

FLAME DATA

Slightly oxidising flame. For bare wire use High Temp Brazing Flux.

WELDING INSTRUCTIONS

For more details on welding of Brazing Alloys, please see our Information Sheets.
 Visit: www.westbrookwelding.co.uk/downloads