XTR LFB Bare & Coated

AWS A5.8 (fka A5.27) RBCuZn-C

Description:

RBCuZn-C, commonly called LFB Bare or Coated is a general purpose oxyacetylene/brazing rod used for joining various ferrous and nonferrous metals such as carbon steel, copper alloys, cast iron, malleable iron, stainless steel, and some nickel alloys. A must in every welding shop is XTRweld Low Fuming Bronze)

Typical Applications:

XTR LFB Low fuming bronze (bare and flux coated) is a general-purpose, copper base alloy brazing rod used extensively for gas brazing steel, copper alloys, cast iron, nickel alloys and stainless steel. Its low fuming characteristic and good mechanical properties make this alloy a widely used general-purpose product. Preheating is recommended for some applications and a bronze brazing flux is required if the rod is not coated. This brazing rod has a low melting point making it easily machinable and excellent for sheet metal work. This alloy also possesses high tensile strength and good ductility.

If using flux coated product (White), there is no need for additional flux. When using the bare (non-Coated) product, be sure to use a borax-boric acid flux.

Chemistry:

	Typical	AWS Spec. Single values are max.
Copper (Cu)	59.550	56.0-60.0
Zinc (Zn)	38.784	Bal.
Tin (Sn)	0.985	0.80-1.10
Iron (Fe)	0.435	0.25-1.20
Manganese (Mn)	0.120	0.01-0.50
Lead (Pb)	0.004	0.050
Aluminum (Al)	0.002	0.010
Silicon (Si)	0.120	0.04-0.15

Mechanical Properties: (As Welded)

	Typical	AWS Spec. Single values are min.
Tensile Strength	60-68k psi	ns
Yield Strength	64,000 psi	ns
Melting Point	1,630°F	-
Solidification	1,590°F	-
Brazing Range	1,330-1,550°F	-
Brinell Hardness	80-105 Brinell	-
Color	Yellow Brass	

Welding Positions:

H, V

Recommended Procedures:

1. Bevel cracks or heavy sections. Be sure to clean all areas to be joined or built-up thoroughly
2. Joint clearances should not exceed 0.13mm
3. Using a slightly oxidizing flame, preheat the part to be brazed. If using LFB Bare, dip the rod into the bronze brazing flux (no need for more flux if using XTR LFB Coated Rods) and then back to the area being brazed, while keeping the torch in continuous motion to avoid any overheating. Molten drops of LFB will follow the heat of the torch flame
4. When using flux coated LFB, there is generally no need clean flux residue between passes
5. Allow the part to cool slowly before removing any slag, then use a wire brush to clear
6. Repeat as necessary to fill your joint

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