DrillTec 8800

Composite brazing rod for wear protection.

Description:
A Flux-coated bronze/tungsten carbibe rod for use with the oxy-acetylene process for applications requiring excellent cutting properties along with abrasion and impact resistence in media such as sand, gravel, earth, minerals etc. also recommended for tools to remove drill rods in well drilling.

- A composite torch rod : consisting of hard carbide particles dispensed through a tough alloy matrix
- Unprecedented cutting actoin
- Outstanding Resistence
- Carbides of low suseptibility to spliting and cleavage
- Range of carbide sizes in tough matrix
- Dual rod design to facilitate initial 'tinning'

Technical Data:
Mechanical Data :
Hardness (Matrix).....~180 HB
Hardness (Hard Phases).....1350-1650 HV
Working Temperature.....~910˚C

Carbide Mesh Size Range	***Flux Coating Colour***
1.6 to 3.2mm	Pink
3.2 to 4.8mm	Yellow
5.0 to 6.5mm	Blue

Applications:
For anti-wear protective coatings on parts in alloy and non-alloy steels.
Applications include drills, wear plates, pipe handling equipment and ripper teeth.

Procedure for use:
Ensure that component surfaces are clean and free from contaminents, oxides etc., which may affect wettability, grind the overlay surface for maximum deposition rates.
Technique:
Adjust oxy-acetylene flame setting to slightly oxidising with a large tip size to achieve a broad, soft flame. Use the 'Pure Matrix' end of the rod where pre-tinning is required. Heat tinned area to melting point, then direct the flame onto the rod until the flux begins to melt and the alloy begins to flow. Continue heating work slightly ahead of the melting flux and alloy.
Rotating the rod assures uniform distribution of carbides. Avoid the inner cone of the flame coming into contact with the rod and workpiece to prevent overheating.
Deposit the required shape and thickness of deposit, finally flame 'machining' for an effective surface contour.

Welding Parameters:
F, HF
PA, PB, according to EN439

Storage and Handling:
Safely stack and store products in a dry location to avoid humidity pickup or coating damage.

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