

WELDING RODS

TUNGSTEN CARBIDE COMPOSITE BRAZING RODS

TECHNICAL DATA

PRODUCT DESCRIPTION

Kennametal's Tungsten Carbide Composite Brazing Rods are manufactured using only premium, clean, Kenface™ WC-Co particles. The quality of WC-Co particles allows for excellent wetting of the tungsten carbide particles during deposition, thereby virtually eliminating "burnt" carbides and premature breakdown of the deposit.



APPLICATIONS

Kennametal offers two types of Tungsten Carbide Composite Brazing Rods for various applications:

Cutting Grades – These rods utilize larger cemented carbide particles where cutting action is required, such as metal-cutting or earth-cutting applications. Standard size rods are 1/2" x 3/8" x 18" with 70% Kenface WC-Co fill that is processed to produce sharp and blocky grains.

Wear Grades – These rods incorporate finer mesh-cemented carbide to ensure maximum protection to the base metal. Standard size rods are 1/2" x 3/8" x 18" with 65% Kenface WC-Co fill that is processed to have a higher packing density.

TYPICAL PHYSICAL PROPERTIES

Material Master	Binder	Mesh Size (in)	Kenface Fraction	Application
1821139	CuNiZn	2 x 3	5/16 x 1/4	Cutting Grades
1821140	CuNiZn	3 x 4	1/4 x 3/16	
1821141	CuNiZn	4 x 6	3/16 x 1/8	
1821142	CuNiZn	6 x 8	1/8 x 1/16	
1820922	CuNiZn	8 x 14	3/32 x 1/16	Wear Grades
1821135	CuNiZn	10 x 20	5/64 x 1/32	
1797378	CuNiZn	2 x 3	5/16 x 1/4	
1797379	CuNiZn	3 x 4	1/4 x 3/16	
5359539	CuNiZn	10 x 20	5/64 x 1/32	Tinning
1818065	CuNiZn	—	—	

DEPOSITION

Kennametal's Tungsten Carbide Composite Brazing Rods can be applied to almost any horizontal surface with an oxy-fuel torch utilizing a neutral-to-2X carburizing flame. The area should be cleaned and preheated prior to application to ensure proper wetting of the carbides to the metal substrate.

PACKAGING

Product typically ships in 20-lb. (9-kg) package.

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