

# 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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