

Product group: 097 Product number: 778992

TIG welding rod for aluminium brass or Yorcalbro pipes.



Product information

This product supersedes product no: 519736

Flux coated TIG welding rod for brasses and bronzes, specially developed for aluminium-brass alloys known as yorcalbro. This alloy is frequently used in seawater cooling systems.

Features

- High mechanical strength and toughness.
- Flux coating in serrations on rod surface.

Benefits

- Less possibility for joint failure during operation.
- No need for additional flux outside pipes.

Specification

General

Invent Hazard Material (IMO/EU) classification	NA
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Dimensions/Weight

Diameter [mm]	2.4
Weight [kg]	1.2

Technical data

AWS	DC-
Polarity	

Documents

[sd-IALBRO-237-MF--GB-Rev3](#)

[SDoC and MD for IHM](#)

Directions for use

The label on each container fully identifies the contents, and also gives basic information on application areas. Complete information on each rod, and instructions for use are given in the handbook for Maritime Welders.

Use pure argon as shielding gas

Welding guidelines:

Piping must be unstressed before welding Cold bent piping should be annealed at 400–500°C for approx. 20–30 min
As a general rule, pipes with a thickness up to and including 1.5 mm may be butt welded with a 1.5 mm aperture, no V-groove being necessary. For thicknesses exceeding 1.5mm, a 70° V-groove with 1.5 mm root gap is recommended
Thoroughly clean the welding area with a steel brush or emery paper
Strike the arc on a separate piece of metal placed close to the weld zone.
Welding continuous beads as quickly as possible. When the arc is extinguished the groove must be cleaned before the bead is continued
Base material temperature during welding should never exceed 150°C
Completed welds, as well as the area covering approx. 15 cm on either side of the bead should be annealed. Annealing temperature 300–400°C for 30–40 min.
Use a contact thermometer when annealing Yorcalbro pipes

Related products

Is frequently bought together with

604850
IMS-210 2.0 X 500 MM1,5KG
602979
18/8MO-221 2.0 X 500 MM0,5KG

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