

Product group: **092** Product number: **764485**

Braze welding rod for joining and surfacing cast iron and gas welding cast iron to steel.

## Product information

This product supersedes product no: **682310**

A braze welding rod specially developed for joining, rebuilding or filling cracks in cast iron, malleable iron and cast iron/steel joints. The deposit has high tensile strength and the same colour and structure as cast iron.

The rod is not flux-coated and should be used with Unitor Cast Iron Flux 236, product number 764487



### Features

- High tensile strength
- Colour of cast iron
- Fuses to oil contaminated cast iron
- Soft ductile deposit

### Benefits

- No colour difference base material and deposit
- Bonding without porosity in deposit
- Oil impregnated cast iron may also be gas welded
- Machinable deposit

## Specification

### General

Invent Hazard Material (IMO/EU) classification	NA
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### Technical data

AWS	A5.15: R-C1
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## Documents

[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.

Flame setting: Slight oxygen surplus

## Related products

### Is part of bundle

**589861**  
GASWELDING CABINET COMPLETE

### Is frequently bought together with

**764487**  
CAST IRON FLUX 236 F. 250 G

**233551**  
FC-BRONZE 261 2.0 X500MM 1,0KG

**633198**  
GAS IGNITOR TRIPL. 2 PCS

**233601**  
AG 60 252 2.0 X 500MM 0,5KG

**519744**  
AG 45 253 2.0 X 500MM 0,4KG

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