

XP Cu BRAZE 773

OXY-FUEL BRAZING



CLASSIFICATIONS

EN ISO 17672	AWS - A5.8
Cu 773	RBCuZn-D

KEY FEATURES AND APPLICATIONS

- Cu BRAZE 773 is a high strength, corrosion resistant brass brazing alloy with addition of nickel.
- Typically used in the joining of steel to steel or carbide to steel.
- Due to the high zinc content, the heating cycle should be minimised to avoid zinc vaporisation.
- Suitable for use with our XP FLUX CU1.
- Typically used in tubular manufacturing for items like metal furniture and bicycle frames etc.

CHEMICAL COMPOSITION OF WIRE %

	Cu	Zn	Si	Ni
MIN	46.0	Remainder	0.15	9.0
MAX	50.0		0.2	11.0

Single values are maximum values according to EN ISO 17672

BRAZING TEMPERATURE RANGES

Solidus Melting Temperature	Liquidus Melting Temperature	Recommended Brazing Temperature
890°C	920°C	~940°C

Temperature ranges are not guaranteed since actual as welded conditions depend on numerous variables

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP50682	1.6	1000	2.5	PAP 20 Tube
XP50683	2.4	1000	2.5	PAP 20 Tube
XP50684	3.2	1000	2.5	PAP 20 Tube