

## COMWELD COMCOAT T

### PRODUCT DATA SHEET

#### A LOW FUMING TOBIN BRONZE FILLER ROD

890  
°C



#### GAS AND TIG WELDING CONSUMABLES

##### COMWELD COMCOAT T

- Flux Coated Tobin Bronze Rod.
- Recommended for the 'Self Fluxing' Fusion Braze Welding of Selected Brasses & Bronzes.
- Suitable for Low Strength brazing of Steels.
- Not Suitable for Cast Irons.
- WHITE Flux Colour for Instant I.D.

##### CLASSIFICATIONS:

|                          |            |
|--------------------------|------------|
| AS 1167. Parts 1 & 2:    | R Cu Zn-A  |
| AWS/ASME-SFA A5.8/A5.27: | RB Cu Zn-A |

##### JOINING PROCESS:

Gas (Fusion and Braze) Welding only.

##### TYPICAL WELD DEPOSIT PROPERTIES:

|                             |                            |
|-----------------------------|----------------------------|
| Weld Metal Tensile Strength | 400 MPa                    |
| 0.2% Proof Stress           | 110 MPa                    |
| Elongation                  | 45%                        |
| Approximate Melting Point   | 900°C                      |
| Weld Metal Density          | 8.41 gms / cm <sup>3</sup> |

DESCRIPTION AND APPLICATIONS:

Comweld Comcoat T is a low fuming Tobin Bronze filler rod recommended for the self fluxing fusion welding or braze welding of selected brass and bronze alloys. It is also suitable for the non-critical brazing of mild steel in low stress applications. Comweld Manganese Bronze or Comcoat C is the preferred filler rod for the higher strength braze welding of ferrous metals.

Comweld Comcoat T Tobin Bronze is the ideal self fluxing filler rod for welding selected brass and bronze alloys and is also used for the braze welding of mild steel in low stress applications such as the 'filling' of car body panels.

PROCEDURE FOR BRAZE WELDING:

- 1. Thoroughly clean all areas to be joined.
- 2. Adjust the flame to slightly oxidising.
- 3. Preheat the edges to be joined to a dull red colour. Melt the end of the flux coated rod and, at the same time, heat both edges of the job to an equal degree. Ensure that tinning has taken place on the required surfaces.
- 4. Continue adding the rod to build up the joint to the desired size and shape.
- 5. Allow the joint to cool and remove the flux residue with a wire brush or by immersion in a dilute acid solution followed by a water rinse.

PACKAGING DATA:

| ROD SIZE (MM) | PACK WEIGHT / TYPE | EASYWELD HANDI PACK | BLISTER PACK       | APPROXIMATE RODS / KG | PACK PART NO. |
|---------------|--------------------|---------------------|--------------------|-----------------------|---------------|
| 2.4 x 500     |                    |                     | 5 Rod Blister Pack | -                     | 322207        |
| 3.2 x 750     | 5kg Pack           |                     |                    | 19                    | 321236        |

TYPICAL ROD ANALYSIS:

|     |         |
|-----|---------|
| Zn: | 37.5%   |
| Si: | 0.30%   |
| Sn: | 0.50%   |
| Cu: | Balance |

COMPARABLE CIGWELD PRODUCTS:

Comweld Tobin Bronze Bare Rod  
AST1167.1 & .2: R Cu Zn-A