

COMWELD COMCOAT C

PRODUCT DATA SHEET

**SELF FLUXING,
LOW FUMING, MANGANESE
BRONZE FILLER ROD**

890
°C



GAS AND TIG WELDING CONSUMABLES

COMWELD COMCOAT C

- Flux Coated Manganese Bronze Rod.
- General Purpose Brazing Alloy.
- Recommended for Braze Welding of Steels and Cast and Malleable Irons.
- Not Suitable for Copper Pipes in Hot Water Systems.
- BLUE Flux Colour for Instant I.D.

CLASSIFICATIONS:

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

JOINING PROCESS:

Gas (Braze) Welding only.

TYPICAL WELD DEPOSIT PROPERTIES:

Weld Metal Tensile Strength	460 MPa
0.2% Proof Stress	165 MPa
Elongation	35%
Approximate Melting Point	890°C
Weld Metal Density	8.39 gms / cm ³

DESCRIPTION AND APPLICATIONS:

Comweld Comcoat C a self fluxing, low fuming, Manganese Bronze filler rod. Because of its high bond (transverse tensile) strength, it is recommended for the braze welding of steel, cast iron and malleable iron.

Comweld Comcoat C is not recommended for the joining of copper pipes which carry hot water or sea water because of dezincification of the bronze causing failure of the joint. For these applications Comweld Tobin Bronze or Comcoat T should be used.

Comweld Comcoat C Manganese Bronze is the ideal maintenance rod for a wide range of self fluxing braze welding applications including the joining of cast iron, malleable iron, steel, etc - it is a must for the workshop.

PROCEDURE FOR BRAZE WELDING:

1. Thoroughly clean all areas to be joined.
2. Adjust 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 joint surfaces.
4. Melting of the base material is not required in braze welding and care should be taken to control the heat in the joint.
5. Continue adding the rod to build up the joint to the desired size and shape.
6. 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	2.5kg Pack			50	321191
2.4 x 500		20 Rod Handi Pack		-	322020
2.4 x 500			5 Rod Blister Pack	-	322206
3.2 x 750	5kg Pack			19	321186
3.2 x 750		15 Rod Handi Pack		-	322021

TYPICAL ROD ANALYSIS:

Zn:	40.5%
Mn:	0.10%
Si:	0.10%
Sn:	1.0%
Fe:	0.50%
Cu:	Balance

COMPARABLE CIGWELD PRODUCTS:

Comweld Manganese Bronze Bare Rod
AS 1167.1 & 2: R Cu Zn-C