

A5.8 | BRAZING

RBCuZn-B

Nickel Bronze (RBCuZn-B) brazing filler metal is similar to naval bronze but contains manganese and iron which increase the hardness and strength of the weld deposit. It also contains nickel ensuring uniform distribution of the iron in the deposit. A neutral or slightly oxidizing flame and a boric acid/borax type flux should be used.

AWS Specification

AWS A5.8/A5.8M:2011

AWS Classification

RBCuZn-B

Typical Wire Chemistry

Pb	0.05
Fe	0.25 - 1.20
Sn	0.80 - 1.10
Ni (contains Co)	0.20 - 0.80
Al	0.01
Mn	0.01 - 0.50
Si	0.04 - 0.20
Cu	56.0 - 60.0
OTHER	0.50
Zn	REM

Typical Physical & Mechanical Properties

Melting point	1620°F
Solidification	1590°F
Tensile Strength, ksi	65
Elongation%, min	25
Brinell Hardness	92

Brazing Positions

H,V

Available Diameters

1/16", 3/32", 1/8", 5/32", 3/16" & 1/4"