

ARCTEC I080[®] FC FLUX COATED BRAZING ALLOY



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC[®] I080 FC is a low fuming flux coated braze welding alloy with good wetting action. Has superior mechanical properties and meets all specifications for strength, ductility and soundness in braze welding applications.

APPLICATIONS:

ARCTEC[®] I080 FC is recommended for overlays and joining of steel, cast iron, copper, nickel alloys and other nonferrous metal except aluminum and magnesium. Ideal for build up of gear teeth, valve and bearing seats and for general applications in the maintenance shops of a variety of industries.

WELDING PROCEDURE:

Clean the weld zone free of all contaminants such as rust, grease, oil mill scale, etc.,. Heavy sections should be beveled to form a 90° V. Using a neutral flame preheat joint area. When base metal is a dull red color melt some flux off the end of the rod and continue heating until flux liquefies. Melt off a drop of alloy from the rod and continue heating until the alloy flows and bonds readily. Continue this process until the joint is filled. Multiple passes can be made without removing the excess flux between passes.

MECHANICAL PROPERTIES:

Tensile Strength Up to 63,000 psi (434 MPa)
Hardness: 65 HB

OPERATING PARAMETERS:

WELDING PROCESS; TB

Use neutral flame for brazing.

Brazing Range
1670 to 1750 °F 910 to 955°C

Available diameters:	Inch.	3/32"	1/8"	3/16"	1/4"
	mm.	2.50	3.25	5.00	6.00

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Subject to change without notice

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