AN ISO 9001:2015 COMPANY
CERTIFICATE NO.: C755336

RBCuZn-C DATA SHEET

Pinnacle Alloys RBCuZn-C
AWS CLASS RBCuZn-C
CODE AND SPECIFICATION DATA:
AWS A5.8 ASME SFA 5.8; UNS C68100
COMMON NAME: Low Fuming Bronze & Flux Coated Bronze

DESCRIPTION:
Pinnacle Alloys RBCuZn-C (Low Fuming Bronze & Flux Coated Bronze) is used on steel, copper, copper alloys, nickel, nickel alloys, and stainless steel. It is used with the torch, furnace, and induction brazing processes. Fluxing is required, and a borax-boric acid flux is commonly used. Joint clearances from 0.002" to 0.005" are suitable. The solidus temperature is 1590°F and the liquidus temperature is 1630°F. The recommended brazing temperature is 1670-1750°F. This filler metal is supplied as bare rod and as coated rod.

DIAMETERS: 1/16", 3/32", 1/8", 5/32", 3/16", 1/4"

WELDING POSITIONS: All positions

TYPICAL DEPOSIT COMPOSITION:

	AWS Spec	Weld Metal Analysis (%)
Aluminum (Al)	0.01	0.001
Copper (Cu)[a]	56.0-60.0	58.55
Iron (Fe)	0.25-1.20	0.82
Lead (Pb)	0.05	0.01
Manganese (Mn)	0.01-0.50	0.04
Silicon (Si)	0.04-0.15	0.08
Tin (Sn)	0.80-1.10	0.91
Zinc (Zn)	Balance	Balance

NOTE: Single values are maximums.
[a] Copper including incidental Silver

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

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