

## Versa-Braze™ Economical Bronze Alloy

Versa-Braze is a premium bronze brazing alloy for joining, buildup, and overlay of all copper and ferrous alloys.

- Low fuming — minimal emissions
- Special organic binders — reduce flux chipping or peeling
- Free machining
- Superior strength
- Resists corrosion
- Cadmium free



### SPECIFICATIONS

Joint strength.....	67,000 psi/462 MPa
Plastic range.....	35°F/19°C
Working temperature.....	1620°F/882°C
Electrical conductivity .....	24% IACS
Flux coating color.....	Green
Machinability.....	Excellent



### PROCEDURES

#### For Brazing:

Adequately preclean the weld area. For best results, parts will require minimum joint clearance. Use a neutral flame to heat the base metal to a dull red. Melt off a small amount of rod and flux, allowing thin deposits to flow through the joint. Add additional filler metal as needed. Let the completed joint cool at room temperature.

#### For Buildup and Overlaying:

If thick sections are to be overlaid, preheating may be needed. Preheat the starting area to a dull red. Apply filler metal in small deposits and wet out on the base metal in a tinning fashion. Apply successive layers of filler metal until the desired buildup is obtained.



### APPLICATIONS

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| <ul style="list-style-type: none"> <li>• Salt water pumps</li> <li>• Valve seats</li> <li>• Heads</li> <li>• Binders</li> <li>• Spreaders</li> <li>• Sheet metal</li> <li>• Galvanized steel</li> </ul> | <ul style="list-style-type: none"> <li>• Propeller shafts</li> <li>• Automotive</li> <li>• Transmissions</li> <li>• Cultivators</li> <li>• Chemical plant equipment</li> <li>• Foundry defects</li> </ul> | <ul style="list-style-type: none"> <li>• Valves</li> <li>• Engine blocks</li> <li>• Tractor yokes</li> <li>• Rakes</li> <li>• Agitators</li> <li>• Differential housings</li> </ul> |
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Code #	Diameter	Length
205-4-0000	1/8"	18"
205-5-0000	3/32"	18"
205-5-0036	3/32"	36"
371-0-0000	General Brazing Flux (12 oz)	



Available in select sizes only