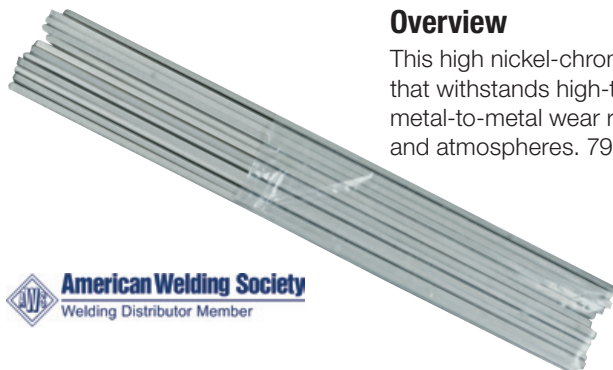




Overview

This high nickel-chrome-silicon-boron brazing alloy provides a very smooth, super-hard deposit that withstands high-temperature conditions 2,000°F (1,100°C). 79 Brazing Alloy is excellent for metal-to-metal wear resistance and also has the resistance of Inconel to corrosive conditions and atmospheres. 79 Brazing Alloy was formerly known as CRONABRAZE™ 99.

Features/Benefits

- Thin flow, very smooth deposit conforms to contour edge being overlayed, requiring minimum of finish grinding
- Very low temperature application
- Works equally well with oxyacetylene or TIG
- Excellent result on all steels, including stainless
- Extremely dense, crack-free, non-porous deposit
- Self-fluxing on clean surfaces
- Non-heat-treatable

Applications

- Overlays on edges of augers and drilling screws, mixer blades, impellers, etc.
- Reforming dies, cams and valves
- Overlaying rails, guides and racks in high-temperature conditions
- Industrial knives, cutters, shredders and choppers
- Construction and agricultural equipment, such as plow blades, discs, post hole diggers, power shovel blades, scrapers, etc.

Method of Application

Torch or TIG

Identification

Dark-silver color metal casting

Directions for Use

Use neutral flame for torch application and a slightly carburizing flame on stainless or high-chrome-content steel. Preheat the line of deposit, then concentrate the flame at the start of base metal application until it reaches a bright red color. Feed 79 Brazing Alloy into the flame and commence drop-by-drop application. Allow each drop to flow out smooth before depositing another. Cover the overlay to retard cooling. On TIG applications (DCSP) use a large, blunt electrode and maintain wide arc gap. Insert the rod into arc stream and move rapidly. Do not allow rod to touch the tungsten electrode.

Technical Specifications

Deposit Hardness: Rc 58 to Rc 62
Application Temperatures: 1,300°F to 1,600°F (700°C to 875°C)

*Formerly CRONABRAZE™ 99