

Technical Data Sheet

Tungsten 75 Brazing Rod



Cronatron™
A LAWSON BRAND



Overview

The Ultimate Cutting and Gripping Overlay

A specially developed composite rod designed to deposit ultra-hard crushed tungsten carbide chips uniformly with a tough, non-porous matrix. Easily applied to a wide range of metals such as cast iron, steels, copper and brass alloys to form a long-lasting cutting and gripping surface.

Features/Benefits

- Composite structure provides the ultimate in cutting action with utmost abrasion resistance
- Uniform equiaxial carbide sizes optimize maximum cutting capabilities
- Superior alloy wets out and flows evenly on most metals
- Non-fuming, easy to use

Applications

- Rock drills
- Core bits
- Augers
- Bark stripper teeth
- Horseshoes
- Shredders

Method of Application

Torch

Identification

Chrome color with visible carbides

Directions for Use

Clean surface of rust, scale, paint, grease, etc. Use neutral flame and No. 7 or higher torch tip. Tin surface by melting a small portion of matrix and heating part to dull red. Apply Tungsten 75 by using a continuous rotating movement of torch and filler. Avoid overheating the carbides. 30F Brazing Alloy may be used as a buildup prior to applying Tungsten 75 and as a touch-up material for the matrix alloy.

Technical Specifications

Matrix: Rb 60 to Rb 70

Carbides: Knoop Hardness 2400 (above highest limits of Rockwell scale)

Bonding Temperature: 1,300°F to 1,600°F (700°C to 875°C)