

Oxford Alloy® Low Fuming Bronze

AWS RBCuZn-C • Bronze Alloys



Key Features

- ❖ General purpose brazing rod used for steel, copper alloys, cast iron, nickel alloys and stainless steel.
- ❖ Low silicon content, which keep fumes to a minimum.

This alloy also is available in a flux coated tig.

Conformances

AWS/ASME SFA 5.8
RBCuZn-C
UNS C68100

Chemical Composition - As required per AWS 5.8						
Cu	Mn	Sn	Pb	Fe	Si	Zn
56.0-60.0	0.01-0.50	0.80-1.10	0.05 max	0.25-1.20	0.04-0.15	Bal
Al	OET					
0.01 max	0.50 max					

Mechanical Properties - As required by AWS 5.8			
	Tensile Strength MPa (ksi)	Yield Strength MPa (ksi)	Elongation %
AWS Requirements	Not Specified		
Typical Results - As welded	390 (56)		

Typical Welding Parameters					
Diameter		Process	Volt	Amps	Shielding Gas
in	(mm)				
1/16	1.6	GTAW		70-120	100% Helium
3/32	2.4	GTAW		120-160	
1/8	3.2	GTAW		170-230	

Diameters & Packaging					
Oxford Alloys USA			Oxford Alloys Asia Pacific		
Diameter (in)	Form	Packaging (lbs)	Diameter (mm)	Form	Packaging (kgs)
1/16	GTAW	10 lb tube 40 lb carton	1.6	GTAW	5 kg tube 20 kg carton
3/32	GTAW	10 lb tube 40 lb carton	2.4	GTAW	5 kg tube 20 kg carton
1/8	GTAW	10 lb tube 40 lb carton	3.2	GTAW	5 kg tube 20 kg carton

Actual test results may vary. Refer test result disclaimer on page 160.