DURAMAX™
Inspiring the future generations of welders

PRODUCT DATA SHEET

DMLFB CTD Premium LFB Low Fuming Bronze Wire

Classification: **RBCuZn-C**

AWS A5.8 / ASME SFA 5.8

Low Fuming Bronze Coated

Characteristics, Application or Usage:

DuraMax LFB CTD is a general purpose, copper based alloy brazing rod used extensively for gas brazing steel, copper alloys, cast iron, nickel alloys and stainless steel. Its low fuming characteristics and good mechanical properties make this alloy a widely used product. Preheating is recommended for some applications. This brazing rod has a low melting point making it easily machinable and excellent for sheet metal work.
This alloy also possesses high tensile strength and good ductility.

All Weld Chemical Composition (%)

Cu	Zn	Sn	Fe	Mn	Pb	Al	Si	TOE
56.0 - 60.0	Remainder	0.80 - 1.10	0.25 - 1.20	0.01 - 0.50	0.05 max	0.01 max	0.04 - 0.15	0.50 max

Please note: Copper includes residual silver

Typical Weld Metal Mechanical Properties:

Tensile Strength (PSI)	Melting point	Solidification	Brazing range	Hardness (Brinell)
65,000	1630°F	1595°F	1670 - 1750°F	96 HBW

Available Sizes DMLFB BARE:	*Available Sizes DMLFB CTD:*
1/16" 3/32" 1/8" 3/16" 1/4"	3/32" 1/8" 3/16" 1/4"

Recommended Welding Parameters:

Clean joint area as thoroughly as possible. Bevel cracks or heavy sections. Utilize a slightly oxidizing flame; preheat the part to be brazed. If using DMLFB BARE, dip it into the bronze brazing flux and then back to the area brazed. Apply the torch, keeping it in constant motion to avoid overheating a particular area of the base metal. The molten drops of DMLFB BARE or DMLFB CTD will follow the heat of the torch flame. Keep adding product until the joint is filled.

Note: When using DMLFB CTD additional flux is not necessary and removal of flux residue between passes is not necessary. Allow the part to cool slowly and remove slag with chipping hammer and wire brush.

Note: *Use low range for iron or nickel-based alloy's, middle range for bronze alloys and high range for copper.