

VORAX TINNING RODS OXYACETYLENE WELDING BINDER RODS

CHARACTERISTICS

VORAX TINNING RODS are fume reduced nickel bronze rods containing 10% nickel specially developed for oxyacetylene welding. Coatings have superior mechanical properties and are used in preference to other welding alloys. One of **VORAX TINNING RODS** unique applications is a binder for the sintered tungsten carbide particles with **VORAX EXTREME CS** composite rods containing large sintered tungsten carbides for extended life.

WELDING RECOMMENDATION

Deposits on drilling tools & equipment used in oil & gas well drilling, for tinning & filling in combination with **VORAX EXTREME CS** tungsten carbide composite rods. **VORAX TINNING RODS** are used on oil drilling tool as a complement to composite carbide rods or to braze tungsten carbide inserts on steel.

CHEMICAL COMPOSITION (IN WT-%)

C	Si	Mn	Cr	Ni	Mo	Co	Nb	V	W	B	Ti	Al	Cu	Fe	Zn
	0.1			10									48		bal.

MECHANICAL PROPERTIES

Hardness: 120 HB
Tensile strength: 70.000psi
Elongation: 25%

AVAILABLE SIZES

3,2	4,0	4,8	6,0
✓	✓	✓	✓

NOTE

Tinning is a process of applying a thin coating to the fluxed surface before the main solder is melted in. The procedure is similar in braze-welding, except that, when brazing thin materials, the tinning usually takes place during brazing, in one step rather than two.

The area to be tinned should be free of rust, scale, grease and other dirt. Slowly preheat the area to a maximum of 480°C. Sprinkle the surface with flux to prevent oxides from forming in the molten matrix during application.