

# BRAZ-ROPE - CONTINUOUS BRAZE MATERIAL



Braz-Rope can eliminate variables due to the following process or design characteristics:

## Viscosity

Since Braz-Rope is a dry product, all problems associated with variations in viscosity due to batch-to-batch mixing and shelf life changes are completely eliminated.

## Operator Technique

No longer is the result of applying braze filler metal dependent on the skill or technique of individual operators. With minimal training, the work of all operators will be consistent using Braz-Rope.

## Joint Design

Braz-Rope works just as well in blind joints and joints around inusually contured components, as it does in conventional braze joints.

Braz-Rope is a dry, highly flexible strand of braze filler metal manufactured in rope form and is designed for furnace brazing. It is available in a range of diameters from .030 to .100. Braz-Rope is an extremely dense material with less than 5% organic binders. Braz-Rope is available in all the standard brazing alloys and can also be specially formulated in custom alloys when required.

**Braz-Rope is a unique brazing product\* which can be utilized to eliminate inconsistency in the formulation of braze fillets. In critical braze applications the placing of the correct amount of braze filler metal in the correct location is extremely important. Too much braze filler metal may require expensive secondary machining operations to remove unwanted material from critical surfaces or dimensions. Too little braze material can often result in added costs and production delays.**

Table I Standard BRAZ-ROPE Compositions

Specifications	Nominal Composition	Liquidus Temperature
AMS 4776	73Ni, 4.5Si, 14Cr, 3.1B, 4.5Fe	1970° F
AMS 4777	82Ni, 4.5Si, 7.0Cr, 3.1B, 3.0Fe	1830° F
AMS 4778	92Ni, 4.5Si, 3.1B	1900° F
AMS 4779	94Ni, 3.5Si, 1.8B	1950° F
AMS 4782	71Ni, 10Si, 19Cr	2075° F
B50TF143	77Ni, 8Si, 15Cr	2075° F
AMS 4786	70Au, 8Pd, 22Ni	1915° F
AMS 4787	82Au, 18Ni	1740° F
AMS 4765	56Ag, 42Cu, 2.0Ni	1640° F
AMS 4767	92.5Ag, 7.2Cu, 0.22Li	1635° F

## How to apply

Braz-Rope can be applied with brazing cement, or where joint design permits, by simply laying it into the joint. Braz-Rope's extreme flexibility allows for application around tight radii and over bends. It is recommended that Braz-Rope be supported in place so that it is held during the brazing operation.

## Storage

No refrigeration is necessary for storage. The recommended shelf life is a minimum of one year in normal room ambient conditions.

## Ordering Information

Braz-Rope is supplied by the pound. to order specify alloy desired, diameter required and quantity in pounds.

For reference purposes please note that one pound of .06 diameter material approximates 120 feet, one pound .03 diameter approximates 360 feet.