

# SHUBER G 385FC

## BRONZE ALLOY - FRICTIONAL WEAR RESISTANCE



### DESCRIPTION

SUPER TOUGH BRAZING ALLOY FOR JOINING AND BUILD-UP OF STEELS, CAST IRON, COPPER AND NICKEL ALLOYS. Alloyed with nickel for perfect balance of hardness, toughness, high strength and corrosion resistance.. Weld deposits are dense, fully machinable and exhibit outstanding resistance to frictional wear. OUTWEARS ORDINARY BRONZE NEARLY 4 TIMES AND STEEL 3 TIMES IN FRICTIONAL WEAR APPLICATIONS. Ideal for build-up of broken gear teeth, worn bearings, valve seats, friction guides and resurfacing worn or undercut shafts.

### SPECIAL FEATURES

- Quick "freezing" properties prevents running or sagging of deposits.
- Weld deposit is workhardening in service.
- Can be applied at "black heat" preventing warpage & distortion.
- Very low coefficient of friction.

### APPLICATION INSTRUCTIONS

Clean joint area of surface oxides. For cast iron, joint area should be seared with an excess oxygen flame prior to preheating. Adjust torch to a neutral flame and preheat base metal 95-200°C (200-400°F). Keep torch tip at a low angle to the base metal and melt some flux off on the joint area. When flux flows freely, deposit a drop of alloy, playing the flame until it flows out and bonds. Add more alloy, making certain not to continue until the previous drop flows out and bonds readily. Maintain approximately 6 mm distance between flame cone and base metal. Cool slowly after welding and remove flux residues.

### TECHNICAL DATA

TENSILE STRENGTH: 62 kg/mm<sup>2</sup> (80,000 psi)

HARDNESS: 200 BHN

WORKING TEMPERATURE: 900°C (1660°F)