



Drill Bit

Gas brazing filler rod having hard carbides embedded in tough matrix.

Typical Applications:

Drill bits, stabiliser, fishing tool, masonry drill, rotary cutting tool.

Outstanding Features:

- Excellent resistance to high abrasion coupled with pressure.
- Tough copper alloy matrix withstands shock loading.
- Low temperature deposition retains hardness, sharpness and angularity of carbides.
- Optimum abrasion resistance and cutting action.

Recommendation:

Ideal for deposition of carbides uniformly on ferrous and non-ferrous metals. Mining grade carbides ensures consistent quality & retention of cutting edges. Improved wettability permits bonding well below the critical temperature of ferrous metals, especially advantageous for repairing carbide tipped drills.

Procedure:

Clean & degrease the surface to be coated. Use extended portion of carbide free rod for tinning. Adjust oxyacetylene torch to neutral flame. Use large nozzle tip with broad flame. Heat tinned surface to remelting temperature, then direct flame on to rod to deposit matrix and carbides. Avoid overheating. Remove flux residues.

Available Size:

Carbide Mesh Size (mm)		Casting Flux Colour
-3.2	+1.5	Pink
-5.0	+3.2	Yellow
-6.0	+5.0	Blue
-10.0	+6.0	Green

Hardness:

Matrix - 210 BHN,
Carbides - 1250 HV (min)