

Technical Data Sheet

22 Cast Iron Brazing Alloy



Cronatron™
A LAWSON BRAND



 **American Welding Society**
Welding Distributor Member

Overview

Advanced powder-metallurgy-formulated cast iron alloy for joining cast iron with torch or TIG. 22 Brazing Alloy will eliminate days of waiting for a replacement part and at a fraction of the cost.

Features/Benefits

- Easy to use
- Solid, dense and uniform deposits
- No porosity when used with F22 Flux
- Fully grindable for shaping and finishing
- Rusts like cast iron
- Easy to build up missing sections
- Perfect color match
- Exclusive powder-metallurgical formulation promotes low-temperature fusion of deposits
- No dangerous copper fumes

Applications

- Housings
- Manifolds
- Engine blocks
- Sprockets
- Gears
- Pulleys
- Pumps
- Casting defects
- Frames
- Furnace grates

Method of Application

- Oxyacetylene torch or tungsten inert gas

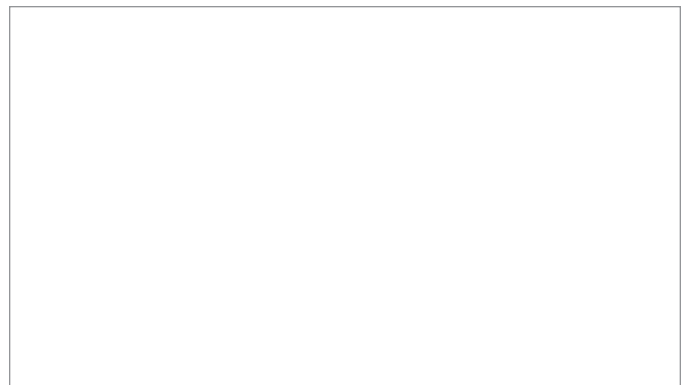
Identification

- Bare – Cast iron gray color

Directions for Use

Thoroughly clean the areas to be welded. Defects should be “U” grooved whenever possible. Cronacut Eagle™ 1100 is ideal for such preparation. Sprinkle a little F22 Flux on the work, then warm the welding rod with the torch and dip it into the flux. Next, heat the area to be welded with the torch. Use a neutral flame, bringing the iron on both sides of the break to about its melting point. Melt both sides of the break and the rod together. Keep dipping the rod into the flux as more is needed.

On heavy work, apply some flux by hand to the work if you are not getting enough on the rod. Finish the surface by manipulating the torch flame – not by using more flux. Cool slowly. Do not quench.



Technical Specifications

- Tensile Strength: 53,000 PSI (365 MPa)
- Hardness: Rc 18 to Rc 20

Technical Tips

With oxyacetylene torch, use a neutral flame with ample amounts of F22 Flux. For TIG applications, use DCSP Argon Flow of 16 to 24 CFH and a tungsten electrode of 1/8" to 5/32" in diameter depending on metal thickness.