



WASHINGTON ALLOY'S Quality
Management System is
Certified to ISO 9001:2008
Cert # 05-R0925

NICKEL SILVER ALLOY

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION:

Washington Alloy Nickel Silver filler metal contains 10% nickel and is used primarily for brazing or oxyacetylene welding of steel or cast iron base metals. The weld deposits of Washington Alloy Nickel Silver have very high tensile strength, good ductility and excellent corrosion resistance. The weld deposits are machinable and work hardens when put into service. Nickel Silver is commonly used for building-up or overlaying worn parts such as gear teeth, bearings and valve seats. This excellent alloy is typically used on tubes & tubular structures such as bicycles, metal furniture or railings. A boric acid / borax flux is required for bare rods. Preheating may be desired for some applications and a neutral or slightly oxidizing flame is recommended. Order as bare or flux-coated. It is also used in the matrix of our Tungsten Carbide rods where it acts as a "binder" for the tungsten carbide particles.

CHEMICAL COMPOSITION, Weight Percent:

Copper	46.0-50.0	Iron	0.25-1.20
Zinc	Balance	Manganese	0.01-0.50
Phosphorus	0.25 max	Silicon	0.04-0.15
Total Others Elements	0.50 max including Pb of 0.05 and Al of 0.01 on each		

PHYSICAL DATA: Typical

Solidus	1690°F (921°C)
Liquidus	1715°F (935°C)
Brazing Range	1720-1800°F (938-982°C)
Color	Light Yellow Brass
Hardness as welded	90-110 Brinell
Tensile Strength	80-98,000 psi

AVAILABLE SIZES:

TCU NS/ =Bare Rods of 1/16, 3/32, 1/8, 5/32, 3/16, 1/4, 5/16, 3/8
TCU NS = Flux Coat Rods of 1/16, 3/32, 1/8, 3/16, 1/4
Other sizes available – please inquire

SPECIFICATIONS:

AWS A5.8/A5.8M
ASME SFA5.8
CDA C77300

RBCuZn-D
RBCuZn-D

NOTICE AWS A5.27 HAS BEEN CANCELLED



DC 10-2012

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