



TECHNICAL INFORMATION SHEET

TUF-KUT TUNGSTEN CARBIDE BRAZING ROD

NOMINAL CHEMICAL COMPOSITION%:

Cu	46.0 – 50.0
Ni	9.0-11.0
Sn	3.0
Zn	Remainder
Other (Total)	0.50
Carbide	1/4" Carbide bits

TYPICAL PHYSICAL PROPERTIES:

Solidus	1690°F (921°C)
Liquidus	1715°F (935°C)
Brazing Range	1720°F- 1800°F (940°C -980°C)

BRAZING PROCEDURE AND PROPERTIES:

Tuf-Kut is a composite rod consisting of copper, nickel, and zinc with ¼ inch carbide bits. This cadmium free high temperature alloy will resist extreme abrasion.

- To apply Tuf-Kut it's recommended to first braze a layer of Harris 170 and apply Tuf-Kut on top of the layer. This combination provides the highest strength for retaining the carbide chunks. When the carbide becomes exposed you can reheat the carbide area and add more alloy.

AVAILABLE FORMS

Rod only 5lbs. package.
Dia. 3/16 x 14" x ¼ carbide bits.

RECOMMENDED FLUX:

Harris 600 powder flux or Harris 17 paste flux.

SPECIFICATION COMPLIANCE:

ANSI/AWS A5.8 classification RBCuZn-D (Rod Only)

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

STATEMENT OF LIABILITY- DISCLAIMER:

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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Additional information available at our web site: www.harrisproductsgroup.com