

Last updated: 26/06/2023 13:39:42

# IALBRO-237 MF 2.4 X 500MM 1.2KG

Product group: **097** Product number: **778992**

TIG welding rod for aluminium brass or Yorcalbro pipes.



## Product information

This product supersedes product no: **519736**

Flux coated TIG welding rod for brasses and bronzes, specially developed for aluminium-brass alloys known as yorcalbro. This alloy is frequently used in seawater cooling systems.

### Features

- High mechanical strength and toughness.
- Flux coating in serrations on rod surface.

### Benefits

- Less possibility for joint failure during operation.
- No need for additional flux outside pipes.

## Specification

### General

|  |    |
|--|----|
| Invent Hazard Material (IMO/EU) classification | NA |
|--|----|

### Dimensions/Weight

|               |     |
|---------------|-----|
| Diameter [mm] | 2.4 |
| Weight [kg]   | 1.2 |

### Technical data

|          |     |
|----------|-----|
| AWS      | DC- |
| Polarity |     |

## Documents

[SDoC and MD for IHM](#)

[sd-IALBRO-237-MF--GB-Rev3](#)

## Directions for use

The label on each container fully identifies the contents, and also gives basic information on application areas. Complete information on each rod, and instructions for use are given in the handbook for Maritime Welders.

Use pure argon as shielding gas

### Welding guidelines:

Piping must be unstressed before welding Cold bent piping should be annealed at 400–500°C for approx 20–30 min

As a general rule, pipes with a thickness up to and including 1.5 mm may be butt welded with a 1.5 mm aperture, no V-groove being necessary. For thicknesses exceeding 1.5mm, a 70° V-groove with 1.5 mm root gap is recommended

Thoroughly clean the welding area with a steel brush or emery paper

Strike the arc on a separate piece of metal placed close to the weld zone.

Welding continuous beads as quickly as possible. When the arc is extinguished the groove must be cleaned before the bead is continued

Base material temperature during welding should never exceed 150°C

Completed welds, as well as the area covering approx. 15 cm on either side of the bead should be annealed. Annealing temperature 300–400°C for 30–40 min.

Use a contact thermometer when annealing Yorcalbro pipes

## Related products

Is frequently bought together with

**604850**

IMS-210 2.0 X 500 MM 1,5KG

**602979**

18/8MO-221 2.0 X 500 MM 0,5KG

This page is printed from

<https://www.wilhelmsen.com/product-catalogue/products/welding/arc-welding-consumables-and-storing/tig-welding-rods-and-fluxes/albro-237-1f-2.4-x-500mm-1.2kg>