

Premium Tungsten Carbide Rod with High Abrasion Resistance

# Xuper<sup>®</sup> DrillTec 8800



## BRAZING

- Recommended for use on steels and cast iron
- Improved weldability permits bonding at a temperature well below the critical temperatures of ferrous metals
- Outstanding “cutting action”
- Excellent resistance to wear caused by abrasion and impact
- Diamax<sup>®</sup> particles offer excellent resistance to erosive attack



## DESCRIPTION

Xuper Dril-Tec 8800 is a torch alloy manufactured under rigorous conditions which prevent loss of de-oxidizers and Diamax particle erosion. The alloy formulation consists of hard Diamax particles dispersed throughout a copper-base alloy that forms the matrix. 8800 alloys also include the most advanced, ATMOSIN containing XFC<sup>®</sup> flux coatings for maximum de-oxidizing and cleansing action during deposition. Improved weldability permits bonding at a temperature well below the critical temperatures of ferrous metals. Recommended for use on steels and cast iron.

## TECHNICAL DATA

Typical Hardness: Diamax Particles: RA 89-91  
Matrix: 200 BHN  
Bonding Temperature: 1400-1600°F (760-870°C)  
Matrix alloy work hardens in service

### Sizes Available:

Flux Color	Diamax Mesh Size Range
Blue	-1/4" + 3/16" (-6.4mm +5mm)
Yellow	-3/16" + 1/8" (-5mm +3.2mm)
Pink	-1/8" + 1/16" (-3.2mm +1.6mm)

## PROCEDURE FOR USE

Clean and degrease the surface. Use the "pure matrix" end where pre-tinning is required. Use a neutral flame with a large tip size to achieve a broad flame. Heat tinned area to melting temperature, then direct flame onto rod until flux melts and alloy begins to flow out. Continue heating the work slightly ahead of the melting flux and alloy. Rotating the rod assures uniform distribution of Diamax particles. Avoid working in too closely with inner flame cone to avoid overheating.

## TYPICAL APPLICATIONS

- Augers
- Bucket Teeth
- Burning Shoes
- Composite Drills
- Cutters
- Drills
- Masonry Drills
- Plowshares
- Reamers
- Pilots
- Junk Bits
- Earth Moving Equipment
- Rotary Cutting Bits
- Rotary Cutters
- Rotary Cutting Shoes
- Drill Nuts

### Typical Industries

- Agriculture
- Construction & Earth Moving
- Mining & Quarry
- Municipal Highway Departments
- Petroleum
- Utilities

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