

Wrought Iron #2 -How To Weld

- Can be Oxyacetylene or Braze welded
- Oxyacetylene (gas) welding is stronger and is the more commonly used method than braze welding on wrought iron
- Use a neutral flame to weld wrought iron using either a low-alloy steel gas welding rod (**RG60**) or a low-carbon steel gas welding rod (**RG45**). No flux is required because the weld and the adjacent surfaces have plenty of protection against oxidation, as the slag melts at a temperature considerably below the wrought iron base metal
- Slag will rise to the surface when gas welding at a relatively low temperature, however, this does not mean proper fusion has taken place. Keep the filler rod immersed in the molten puddle and continue to apply heat until the base metal breaks down to

ensure complete fusion



- When **Braze welding**, the filler rod melts above **842 degrees F** but below the melting point of the base metal (no fusion takes place as in oxy welding). The filler metal merely **adheres** to the base metal. While not as strong as a weld formed by gas welding, the low temperatures used in braze welding result in less stress and distortion
- A neutral oxyacetylene flame is also used to braze weld wrought iron using a bronze gas welding rod (**RB CUZn-A**), a nickel gas welding rod (**RB CUZn-B**), or a manganese bronze gas welding rod (**R CUZn-C**) along with a flux designed for

braze welding wrought iron

