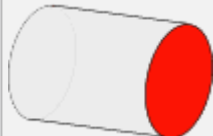


385 BRASS

Brass alloy 385 has been specifically developed for the mass production of brass components in high speed lathes, providing maximum output and long tool life. Typical applications are nuts, bolts and screw threads.

Colour Code	Stocked Sizes	
 Red (Bar End)	Rounds	4.76 mm to 101.6 mm diameter
	Squares	9.52 mm to 50.8 mm A/F
	Hexagons	9.52 mm to 44.45 mm A/F
	Bar Finish	
	Cold Drawn	

Related Specifications

Australia	AS 1567-385
Germany	DIN 1.7672 CuZn39Pb3
Great Britain	BS 2847-CZ121
USA	ASTM B455 UNS C38510

Chemical Composition

	Min. %	Max. %
Copper	56	60
Lead	2.5	4.50
Zinc		Remainder

Typical Mechanical Properties

Tensile Strength Mpa	400
Yield Strength Mpa	200
Elongation %	20
Hardness HV	135

Heat Treatment

Annealing	Heat to 425°C - 600°C, hold until temperature is uniform throughout the section and cool in furnace.
Stress Relieving	Heat to 250°C - 300°C, hold until temperature is uniform throughout the section.
	Check Test Certificate if critical for end use.

Hot Working

Fair hot working properties within an ideal temperature range of 700°C to 800°C.

Cold Working

Exhibits poor cold working properties, and cold heading is not recommended.

Machining

A free cutting brass specifically developed for maximum output and longest tool life, ideally suited for mass produced brass components.

Corrosion Resistance

Has good corrosion resistance to weathering, with a fair resistance to many waters.
It should not be used in contact with ammonia, or ammonia compounds, as it may suffer stress corrosion cracking.

Plating

Provides good surface finish through either polishing, and/or electroplating.

Joining Properties

Soldering - Whilst good results can be achieved from Silver soldering, better results can be achieved from Soft soldering.
Brazing - Good results can be achieved from brazing.
Welding - Fair results can be achieved from both Oxy acetylene & Carbon arc welding. However Gas shielded and coated metal arc welding, and resistance welding is not recommended.

Interlloy believes the information provided is accurate and reliable. However no warranty of accuracy, completeness or reliability is given, nor will any responsibility be taken for errors or omissions.