


**Soudotec 56 FC**
**COPPER ALLOY****DESCRIPTION**

Universal bronze flux-coated rod for brazing ferrous and non-ferrous metals.

**CHARACTERISTICS**

- Minimal smoke release
- Dense and porosity-free deposits
- Excellent fluidity
- Deposits suitable to plating
- Good mechanical properties
- Ideal for dirty, oily or rusty steel

**TYPICAL APPLICATIONS**

Ideal for **brazing galvanized steel**. Thin sheet metal, body work, cast iron parts. Agricultural industry, civil engineering, piping, furniture, house appliances, cast iron to steel assembling, etc.

**PROCEDURE**

Clean the brazing area. Chamfer heavy parts and preheat the joint. Melt the flux from the end of the rod until it becomes fluid. Melt the filler metal to adhere easier to the base metal. Allow to cool down slowly. Use a neutral flame. For very dirty parts, or when much fluidity is required, use flux **Soudotec F081**.

**MECHANICAL PROPERTIES**

Tensile strength: 66 000 psi (455 MPa)  
 Elongation: 26 %  
 Hardness (as-welded): 115 BH

**BRAZING PARAMETERS**

Diameter: 3.2 mm (1/8")                      2.5 mm (3/32")  
 Bonding temperature: 760°C (1400°F)  
 Type of flame: Neutral

Also available in bare rods: **Soudotec 56B**

Rév. : 7\_01

*Specialized welding alloys and technology. For technical assistance or for ordering:*

**FSH WELDING Canada**  
 division de/of FSH WELDING GROUP

info@fsh-welding.ca  
 www.fsh-welding.ca

2341, 46<sup>e</sup> avenue  
 Lachine (Mtl), Québec  
 Canada H8T 3C9

Tél : 514.631.7670  
 1.800.361.9097  
 Fax : 514.636.3339