

DESCRIPTION

High strength flux-coated rod with **low silver content** for brazing ferrous metals and copper alloys together or as dissimilar assemblies.

CHARACTERISTICS

- **Excellent fluidity**
- May replace silver alloys in certain applications
- Good adherence to cast irons, copper alloys, stainless and alloy steels
- Deposits suitable to plating

TYPICAL APPLICATIONS

Dissimilar assemblies. Recommended for the repair of tempered steel parts, tools, molds (tool steel), extending drill bits, bearings, fittings, vices, bushings, etc. Do not use on aluminum and/or magnesium alloys.

PROCEDURE

Clean the section to be brazed. Gouge the thick sections and preheat the joint. Heat to obtain a liquid flux. Melt filler metal until it flows and bonds easily with the base metal. Cool slowly. Use a neutral flame.

MECHANICAL PROPERTIES

Tensile strength: 100 000 psi (689 MPa)
Elongation: 25%
Hardness: 200 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 57B**

Rev.: 7_01

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