

## FILLER METAL SELECTION TABLE FOR BRAZING WITH SILVER ALLOYS

PROPERTIES	PRODUCTS								
	6020 FC	6030 FC	6045 FC	TBW 5034	6804	6805	6806	6157	TIMWELL (limited without Ag)
Tensile strength (x 1000 psi)	80	60	75	60	40	40	45	15.5	7
Bonding temperature (°C)	570-620	720-750	650-680	630-730	730-805	705-805	705-805	195	186
High temperature brazing	✓	✓	✓	✓	✓	✓	✓		
Low temperature soldering								✓	✓
Deposit color	Silver	Yellow	Silver	Yellow	Copper	Copper	Copper	Silver	Grey
High capillarity	1	3	2	3	1	2	3	2	
Self-fluxing on pure copper					✓	✓	✓		✓
Stainless steel brazing	1	3	2	3					
Cadmium-free alloys	✓	✓	✓	✓	✓	✓	✓	✓	✓
Copper alloys economical brazing					✓	✓	✓		
Ferrous and non-ferrous metals brazing	✓	✓	✓	✓				✓	
Radiators					2	1		3	✓
Fittings	✓	✓	✓	✓	✓	✓	✓	✓	✓
Stainless steel thin sections								1	
No exterior flux needed	✓	✓	✓	✓	✓	✓	✓		
Sugar refineries	For all brazing/soldering applications in these types of industries, consult the <b>FSH Welding Canada</b> Technical Department.								
Air conditioning									
Food industries									
Hospitals									

1 = Most efficient product(s) ; ✓ = Recommended product(s)

NOTE: Other types of coils, bare rods and shims are also available. Consult the technical data sheet for a specific product or the **FSH Welding Canada** Technical Department for more information.

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This table is not exhaustive; other products may be suitable for certain applications and/or characteristics. Consult the **FSH Welding Canada** Technical Department.