COPPER –SILVER BRAZING-ALLOYS AND FLUXES

Product	Application/Features	Technical details	Form of delivery
850-F 850-B	Our most versatile brazing rod High silver content (56 %) provides the best combination of low melting tempera- ture, high strength and excellent capil- lary flow, good color match on stainless steel. Use on all ferrous and non-ferrous metals (not for white metals). Ideal for application in the food industry (dairies, breweries, bottling companies, hospitals, manufacturing of lamps, etc.)	Melting range:630-660 °C Tensile strength:430N/ mm ² Elongation:>25 % DIN EN 1044: Analysis:Ag,Zn,Sn,Si,Cu	B RODS. Ø 1,5-2,0-2,5-3,0 F RODS Ø 1,5 AND 2,0 mm
845 –F 845-B	A high silver content (45 %) low tempera- ture brazing rod for joining steel, stainless steel, copper, nickel and tungsten alloys. Does not contain cadmium and can therefo-re be used on food or medical equipment. Tin free composition. Highest crack resi-stance. Good ability to fill joint gaps that cannot be tightly controlled.	Melting range:640-680 °C Tensile strength:430N/ mm ² Elongation:>25 % DIN EN 1044:AG 104 Analysis:Ag, Zn, Sn, Si, Cu	B RODS. Ø 1,5-2,0-2,5-3,0 F RODS Ø 1,5 AND 2,0 mm
834-F 843-B	A general purpose economical silver brazing alloy for brazing copper brass, bronze and steels. Especially suitable for maintenance and production brazing when joint gaps are more than 0.15 mm	Melting range:640-730 °C Tensile strength:430N/ mm ² Elongation:>25 % DIN EN 1044: AG 106 Analysis:Ag,Zn,Sn,Si,Cu	B RODS. Ø 1,5-2,0-2,5-3,0 F RODS Ø 1,5 AND 2,0 mm

Bronze Type brazing alloys for brazing steel, cast-iron, galvanized steel

Product	Application/Features	Technical details	Form of delivery
842 BB 842 FB	Multi purpose brazing rod. For strong joints and build-ups on copper, brass, bronze, steel, galvanized and cast iron.	Melting range:875-900°C Tensile strength:350-400N/ mm ² DIN EN 1044:CU 301	B (bare rods)Ø 2,0,3,0 F (flux coated)Ø 2,5mm Length 500 mm
860 BB 860 FB	Silver containing brazing alloy for joining steel, copper alloy and galva- nized steel Excellent bonding and flowing, high strength Unique flux coating allows fast and easy brazing	Melting range:845-865°C Tensile strength:400-450 N/ mm ² DIN EN 1044:	B (bare rods)Ø 2,0,3,0 F (flux)Ø 2,5mm Length 500 mm
865 BB 865 FB	Special nickel bronze alloy for high strength joining and build-ups. Use for overlay-ing and build-up of gear teeth, bearings, shafts, valve seats, wedge bars and steering knuckles, furniture and bicycle assemblies, at- taching carbide cutting tips.	Melting range:845-865°C Tensile strength:400-450 N/ mm ² DIN EN 1044: CU 305	B (bare rods)Ø 2,0,3,0 F (flux coated) Ø 2,5mm Length 500 mm

BRAZING ALLOYS FOR JOINING COPPER AND COPPER ALLOYS

Product	Application/Features	Technical Data	Sizes mm
830	Silver containing self fluxing brazing rod for cop- per and copper alloys. High strength and ductility, excellent vibration resistance. , good electrical con- ductivity. For use on air conditioning and refrigeration tubing, electric motor repairs. Radiators, heat ex- changers bus bars etc. May be used for operating temperatures up to 150 0 C	Melting range:630-660 °C Tensile strength:430N/mm ² Elongation:>25 % DIN EN 1044: Analysis:Ag, Cu, P	1.5 2.0 3.0
820	Economy type copper phosphor alloy rod for cop- per. Self fluxing on copper For use on air conditioning and refrigeration tubing, electric motor repairs. Radiators, heat exchangers bus bars etc. May be used for operating temperatures up to 150 0 C	Melting range:630-660 °C Tensile strength:430N/mm ² Elongation:>25 % DIN EN 1044: Analysis: Cu, P	1.5 2.0 3.0

Low temperature joining (soldering) of different metals

Product	Application/Features	Technical details
22 B	A high strength solder that is free of cadmium, zinc and lead. The deposit stays bright and shiny, therefore it has a close color-match to stainless steel. Soldered joints have good corrosion resistance and can be plated. Ideal for use on stainless steel, brass, bronze, copper, nickel alloys and carbon steels. Typical applications are food and dairy equipment, instruments, jeweler manufac-turing, sanitary apparatus, electrical connections and general maintenance repairs. 22B is a bare wire and is to be used with flux 30 FL	Melting range:220-240 °C Tensile strength:~50 MPa Elongation:>25 % DIN EN 1044: Analysis:,Sn,Ag Sizes: 2 and 3 mm



JOINING COPPER TO BRASS





JOINING TUNGSTEN CARBIDE TO STEEL

FLUXES FOR BRAZING AND SOLDERING

Product	Application/Features	Technical details	Packaging
810 AG	PASTE silver solder flux . Provides maximum wetting and cleaning action on a variety of metals. Use with 850,845,840,5045 . silver solder and other low temp brazing rods	Active range from 550 -800 °C Composition:Boric Acid, Borates, flu borates	1.00 kg
810 HT	High temperature flux for silver brazing of nickel base alloys, mild steels, austenitic and martensitic stainless steels, tungsten carbide, Also recommended for induction brazing	Active range from 550 -800 °C Composition: Boric Acid, Borates, flu borates	1.00 kg PA paste; PD powder
810 CU (21 FL)	General purpose brazing flux in paste form. Can be used with all kinds of brazing rods for brazing steel, cast-iron, brass, bronze. Active range from 800 0 C to 11000 C.	Active range from 800 to 1100 C. Composition: Boric Acid, Borates, flu borates	1.00 kg
40 FL 40 NC	Universal aluminum brazing flux. Has excellent wetting properties on all aluminum and Aluminum alloys. Note: 40 NC with non corrosive flux residue.	Temp. range 440 - 650 °C Composition:Lithium chloride Sodium chloride Potassium chloride	1.00 kg
30 FL	Universal flux for soft soldering. Rapidly dissolves oxides. Can be used on all metals except aluminum. For use with all soft-solders on stainless steel, copper, silver, galvanized steel.	Temp. range 200 - 300 °C	1.00 kg



BRAZING FLUX

GALV. PIPE JOINING - BRAZING ROD 865 FB

22 B LOW TEMP. SOLDER

Flux plays an important part in brazing and soldering. Flux removes oxides during the brazing operation and promotes wetting (bonding) of the filler material.

Fluxes are generally supplied as a paste or a Powder. If supplied as powder the should be mixed with distilled water to form a paste.

Limitation. Fluxes will only remove oxides other contaminants such us oil, rust etc. must be removed by other means (degreasing...) before brazing.

Safety: Fluxes contain acids. do not inhale fumes wash hands with soap and water after

Use. observe safety datasheets remove flux residues after brazing from work piece,