



Sil-Flex™ Cadmium-Free Silver Brazing Alloy

Sil-Flex is a low melting point, thin-flowing alloy for use on all ferrous and non-ferrous metals (except aluminum, magnesium and zinc alloys)

- Cadmium free
- Good electrical conductivity
- Low melting point
- High strength
- Corrosion resistant
- USDA acceptable
- Excellent wettability and capillary action
- Versatile — joins all metals except white metals

SPECIFICATIONS

Joint strength.....	up to 70,000 psi
Elongation.....	36%
Working temp.	1150°F/621°C
Electrical conductivity.....	11.9% IACS
Corrosion resistance	Good
Coating	Orange

PROCEDURES

Thoroughly clean the weld area. Maintain a close fit-up; a joint clearance of 0.003" is ideal. Prefluxing is not necessary for most applications. Uniformly heat the weld area using a carburizing flame. Apply by melting off a small amount of flux and alloy. Allow the deposit to cool naturally. Remove flux residue with warm water.

APPLICATIONS

- Probes/Sensors
- Food service equipment
- Temperature control devices
- Hospital bed frames
- Copper pipe
- Brass and stainless fittings
- Stainless steel instruments: kitchen utensils, dairy equipment, food processing equipment, bakery equipment, etc.
- Hospital equipment
- Chemical plants
- Steel furniture repair
- Electric motors
- Heat exchangers
- Laboratory equipment

Code #	Diameter	Length
262-7-0000	1/16"	18"
361-0-0000	Silver brazing flux (8 oz.)	

