

# BRAZING ALLOYS & SILVER SOLDER

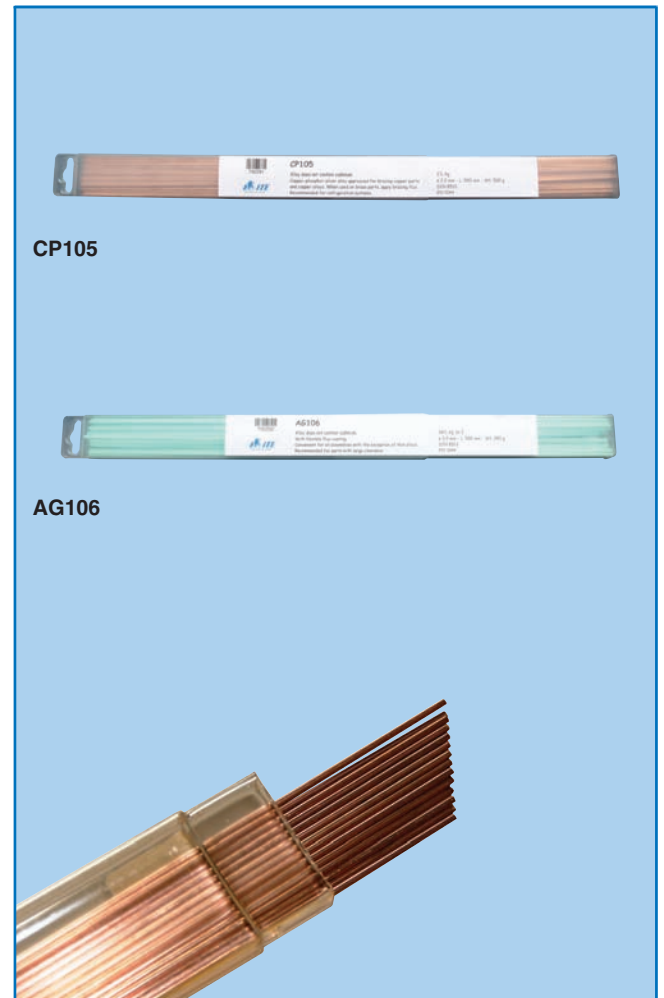
## DESCRIPTION

- These **BRAZING ALLOYS** are used for joining copper, especially for **REFRIGERATION** and **AIR-CONDITIONING**.
- May also be used for joining brass to copper with the use of **FLUX** (no flux is required when brazing copper to copper).
- **With 5% SILVER ALLOY:** Lower melting temperature than that of 0%. Addition of silver makes it more manageable.
- **With 15% SILVER ALLOY:** More silver and less phosphorus gives a low brazing temperature for better control with excellent fill capabilities. The most preferred because its versatility.
- **With 30% and 40% SILVER ALLOY:** Good strength and ductibility. Flows in a sluggish manner making it suitable for loose fittings. For general purpose brazing with a lower silver content making it the most economical cadmium alloys.
- **With 45 and 56% SILVER ALLOY:** Additional silver content gives this alloy a high degree of versatility and extreme thin flowing. Has a very high tensile strength and is especially suitable for joining dissimilar metals.

## 1. PLAIN SILVER ALLOY RODS AUTO-FLUX BRAZING

PART NUMBER	ROD Ø	WEIGHT (gram)	MELTING (°C RANGE)	SILVER (%)
<b>CP105</b>	2	500	645 / 825	2
<b>CP104</b>	2	500	645 / 815	5
<b>CP102</b>	2	500	645 / 800	15
<b>AG106</b>	2	250	630 / 730	34
<b>AG104</b>	2	250	640 / 680	45
<b>RB-4240</b>	2	200	600 / 690	30

Certified EN 1044  
 Cadmium-free



## 2. BRAZING SCOURING FLUXES

PART NUMBER	DESCRIPTION	WEIGHT (gram)	°C TEMP. (Range)
<b>FLUX-800-D</b>	Powder for <b>800 &amp; 806</b>	200	500 / 850
<b>FLUX-1802-D</b>	Powder for <b>1020, 1802 &amp; 4240</b>	200	500 / 780
<b>FLUX-1802-PF</b>	Soft paste	200	500 / 850

SEE ALSO:

- **"SOLDERLENE" PASTE FLUX**
- **"HEAT SEAL STICK" SOLDER**
- **"BLOCK- ITE" HEAT ABSORBER**

