



TBW 5034

SILVER ALLOY

DESCRIPTION

Seamless, tubular flux-cored cadmium-free brazing product with a medium silver content for brazing ferrous and non-ferrous metals; steel, stainless steel, nickel and copper alloys.

CHARACTERISTICS

- No extra flux required.
- No fragile coating
- Quick and easy application
- Longer shelf life of the product
- Reduction of the heat contribution compared to the solid cored rod
- High fluidity and good wettability
- Easy and less cleaning after brazing
- Ratio metal/ flux: 88/12

TYPICAL APPLICATIONS

Ideal for production assemblies. Excellent for brazing tubes and fittings, in electrical industries and for household appliances, etc.

PROCEDURE

Clean the section to be brazed by removing grease and dirt. Heat the rod tip to pulverize liquid flux on the part and to continue to heat until the flux becomes liquid. Cool slowly and remove flux residue by plunging into water. Use a slightly carburizing flame.

MECHANICAL PROPERTIES

Tensile strength: 60 000 psi (414 MPa)

BRAZING PARAMETERS

Diameter: 2.0 mm (5/64") 1.6 mm (1/16")
 Bonding temperature: 630 - 730°C (1166 - 1346°F)
 Type of flame: Slightly carburizing

Rod available in 0.5 kg tube and 6 rod kits, also in coil of 1 kg.

Also available in flux coated rod: **Soudotec 6030 FC** (30% Ag)

Rév.: 21_08

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