



6020 FC

SILVER ALLOY

DESCRIPTION

Universal coated **cadmium-free** rod with **very high silver content** for brazing ferrous and non ferrous metals; steels, stainless steels, copper alloys and nickel alloys.

CHARACTERISTICS

- **Conforms to specifications AWS A5.8: BAg-7**
- Very high capillarity
- High tensile strength
- Exceptional corrosion resistance
- Excellent electrical conductivity
- Good color match with stainless steel

TYPICAL APPLICATIONS

Ideal for joining and repairing stainless steel equipment used in food and dairy industries. Excellent for high vacuum assemblies, laboratory apparatus, tubes, instruments, high pressure fittings, hospital equipment, refrigeration, etc.

PROCEDURE

Clean the section to be brazed by removing grease and dirt. Heat rod tip to obtain a liquid flux. Melt the alloy in the joint through indirect heat. Cool slowly and remove flux residue by plunging into water. Use a carburizing flame.

MECHANICAL PROPERTIES

Tensile strength: 80 000 psi (550 MPa)

BRAZING PARAMETERS

Diameter: 2.5 mm (3/32") 1.6 mm (1/16")
 Bonding temperature: 570 - 620°C (1060 - 1150°F)
 Type of flame: Carburizing

0.5 kg tube and 6 rod kit available

Also available:

- Tubular brazing wire (rods and coil) : **Selectarc TBW 5056**
- Bare rods: **Soudotec 6050B**
- Coil: **Soudotec 6050C**
- Shim: **Soudotec 6050S** (Use with flux **Soudotec F060**)

For carbide brazing, use sandwich (available upon request):

- Shim with cadmium: **Soudotec 6047 SS**
- Shim without cadmium: **Soudotec 6048 SS**

Also available in kit: 1oz of flux and 1oz of silver: **Soudotec 6050 CKF**

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

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