



6045 FC

SILVER ALLOY

DESCRIPTION

Versatile coated **cadmium-free** rod with **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-36**
- High capillarity
- Very good corrosion resistance
- Excellent electrical conductivity
- Flexible coating

TYPICAL APPLICATIONS

Polyvalent use in production and maintenance. Ideal for production assemblies. Excellent for tubes and fittings brazing in electrical industry and for household appliances, 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: 75 000 psi (515 MPa)

BRAZING PARAMETERS

Diameter: 1.6 mm (1/16") 2.5 mm (3/32)
 Bonding temperature: 650 - 680°C (1200 - 1260°F)
 Type of flame: Carburizing

0.5 kg tube and 6 rod kit available

Also available:

- Tubular brazing wire (rods and coil) : **Selectarc TBW 5045** ;
- Bare rods: **Soudotec 6045B*** ;
- Coil: **Soudotec 6045C*** ;
- Shim: **Soudotec Silvershim*** and **Soudotec 6046S*** ;
- Also available in kit 1oz flux / 1oz silver: **Soudotec 6045CKF**.

*To be used with the brazing flux **Soudotec F060**.

Page 21 of 22

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