

High Silver Brazing Alloys - 1/16" Dia. Coils



In refrigeration applications, much of the brazing involves joining copper tubing. However, there are numerous applications where other materials need to be joined (steel, brass, stainless, etc.). These high silver brazing alloys facilitate the joining of these metals. The one alloy in particular which is highly recommended for virtually all above mentioned base metals is Braze® 505. It's advantages over 56% and 45% include:



- It contains 2% Nickel which enhances wetting and strength and facilitates the joining of steels, stainless steel, carbide, etc.
- It doesn't contain tin. This prevents the formation of brittle intermetallics which can cause joint failures when stresses accumulate.
- The flow characteristics can be easily manipulated by either fast or slow heating techniques - this allows bridging of gaps.
- It's available in flux-coated rod for added convenience and ease-of-use: No separate fluxing operation.

Braze® 450 is a general purpose filler metal for joining ferrous, non-ferrous and dissimilar metals with large joint clearances. Cadmium-free. Braze® 505 is the best general purpose filler metal available. It is the only alloy recommended for stainless steel (as it retards/eliminates interface corrosion) and carbide applications. Nickel content provides superior adhesion ("wetting") to base metal surfaces. Available, and especially convenient, as flux coated rod. Cadmium-free.

Braze® 560 is the lowest temperature, Cadmium-free filler metal available. This is a good general purpose alloy for close joint tolerances.

MARS NO.		AWS SPEC	COMPOSITION %					TEMPERATURE	MARS CASE
			AG	CU	ZN	SN	OTHER	MELT FLOW	PACK QTY.
78305	Braze® 450 1oz	BAg-5	45	30	25			1225° F 1370° F	1 24
78306	Braze® 450 3oz								1 24
78308	Braze® 505 1oz	BAg-24	50	20	28	2 Ni	1220° F 1305° F		1 24
78309	Braze® 505 3oz								1 24
78310	Braze® 505 5oz								1 24
78314	Braze® 505 F/C, Flux coated rod, 18" stick x 1/4 lb tube	BAg-24	50	20	28	2 Ni	1220° F 1305° F		1 15

Brazing & Solder Fluxes



Where fluxing is required as part of the brazing operation, Handy Flux is recommended. Handy Flux is an all-purpose flux for use in brazing both ferrous and non-ferrous metals and alloys. Handy Flux conforms to: AWS Brazing Flux Type #3A, Federal Spec. O-F-499d (216185) Type B, Society of Automotive Engineers AMS-3410G. For soldering applications we offer two different flux products depending on the materials to be joined. They include Clean-n-Brite Flux for general purpose applications and TEC Liquid Flux where more aggressive fluxing is required for the more difficult-to-solder materials (e.g. steel, stainless steel, etc.).



For copper-copper, Clean-n-Brite Paste Flux is the flux of choice. For copper-steel applications, TEC Liquid Flux is recommended as it is more aggressive at keeping the metal surfaces to be joined free of oxides. TEC is a more corrosive flux however, and subsequent flux residue removal is recommended.

MARS NO.	DESCRIPTION	MARS PACK	CASE QTY.
78315	Handy Flux - 7oz. jar w/brush cap	1	24
78319	TEC Liquid Flux - 4oz. squeeze bottle	1	48
78320	Clean-n-Brite Flux -4oz. paste w/brush	1	24

Silver Bearing Soft Solders - 1/8" X 1 Lb. Spool



Clean-n-Brite solders are a high strength general purpose solder. They offer a higher strength than Tin/Lead solders and are safe for potable water systems. These alloys are widely used in low stress, low pressure copper-copper and copper-steel applications (e.g. sight glasses where temperature must be kept low, etc.).



Clean-n-Brite is a Lead-free, silver-bearing high-strength solder used for applications requiring close joint clearances.

Clean-n-Brite 6 is a Lead-free, silver-bearing high-strength solder used for applications requiring large joint clearances. It is the easiest Silver-bearing soft solder to work with as temperature range permits "bridging" loose fit-ups if necessary.

Clean-n-Brite No Lead is a Silver-bearing solder with good strength used in potable water system applications requiring no lead.

MARS NO.		COMPOSITION %			TEMPERATURE		MARS CASE
		AG	CU	P	MELT	FLOW	PACK QTY.
78316	Clean-n-Brite	3.6	96.4		431° F	431° F	1 24
78317	Clean-n-Brite 6	6	94		431° F	535° F	1 24
78318	Clean-n-Brite No Lead	0.5	4	95.5	428° F	446° F	1 24