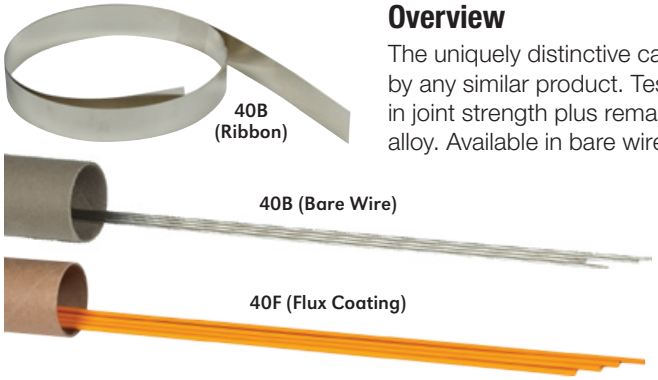
Technical Data Sheet

High Silver Brazing Alloys

TDS

Cronatron™ A LAWSON BRAND



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Overview

The uniquely distinctive cadmium-free, high silver-bearing alloy possesses qualities unmatched by any similar product. Tests made on 32 different metal combinations show unequalled results in joint strength plus remarkable ease of application at the lowest heat level of any cadmium-free alloy. Available in bare wire and flux coated form.

Featrures/Benefits

- Exceptionally high tensile and shear strengths combined with maximum elongation properties
- Very low melting point, flows freely through tight joints at 1,140°F (615°C)
- This high-silver alloy meets state and federal regulations governing food handling and processing equipment
- High corrosion resistance plus excellent electrical conductivity
- Special flux coating facilitates clean, simple application
- Contains no cadmium

Applications

Used in food processing, beverages, bottlers, meat processors, hospitals, all types of laboratories, universities and general industry.

- Stainless steel
- Monel®
- Tool steels
- Nickel alloys
- Chromium steels
- Hospital and laboratory equipment

Method of Application

Torch

Identification

40B bare, 36" ribbon; 40B orange-tipped, bare 18" length; 40F orange flux-coated

Directions for Use

Clean materials to be joined so they are free of grease, oil, jagged edges or burns. Heat broad area along joint line. Keep the flame cone one inch away from rod and produce a continuous fillet. With 40F, rotate the rod slightly as you join the materials.

Technical Specifications

Tensile Strength: 85,000 PSI (586 MPa)
Melting Temperature: 1,140°F (615°C)

Technical Tips

Use F40 Flux with 40B Bare Wire. If additional flux is required for 40F, F40 Flux is also recommended. Flux residue can be removed with warm water.