

2005

Cadmium Free, Premium High Strength, Super Active, Flux Coated Silver Brazing Alloy

GENERAL CHARACTERISTICS:

* 2005 is the most active flux on the market today. 2005 has excellent wetting action on a wide range of metals, especially stainless steels and carbides. This alloy is cadmium free, non-toxic, and easier to use due to the elimination of the glare in the flame. 2005 is the most economical substitute for the higher silver alloys. Charring of the flux has been eliminated.

APPLICATIONS:

With the absence of cadmium 2005 is perfect for the food and drug industries. Use it to join similar and dissimilar metals such as copper, nickel, stainless steel, brass, bronze, Inconel® and Monel®**. Excellent for carbides, light gauge metals, heat-treated parts, and tight fitting joints. Color is silver to light yellow, similar to polished brass.

TECHNICAL DATA:

Tensile Strength.....65,000 psi (483N/mm²)
Working Temperature.....approx. 1275°F (690°C)
Elongation %.....approx. 24%
Corrosion Resistance.....good
Diameter (in) 1/16" 3/32"
(mm) 1.6mm 2.4mm

PROCEDURE:

Prepare surfaces to be joined by mechanical or chemical cleaning. Fixture parts to maintain alignment. Joint clearance should not exceed .003". Heat parts uniformly with a slightly carburizing flame. Place Slik-Sil Thernal Flux directly on the heated joint. When the flux becomes clear and fluid, melt a small amount of alloy onto the joint and continue heating to uniformly spread the alloy through the entire joint area. **DO NOT OVERHEAT THE BASE METAL.** Allow the part to cool slowly, then remove flux residue with warm water.

*Bare rod and flux is available as 2005B. .

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New & Improved

Formulation to Reduce Charring and Increase Flow

LOW SILVER 2005