

2012

CADMIUM FREE, LOW TEMPERATURE, SILVER BEARING SOFT SOLDER FOR FERROUS AND NON-FERROUS METALS

ALL HEAT SOURCES

GENERAL CHARACTERISTICS:

A high strength silver solder that is free of cadmium, zinc, lead, and other impurities. The deposit stays bright and shiny, therefore it has a close color match to stainless steel. Soldered joints have good corrosion resistance and can readily be plated. Available as flux cored, solid wire, and paste.

APPLICATIONS:

Commonly used to join a variety of ferrous and non-ferrous metals when higher strengths are required than normally found with conventional solders. Ideal for use on stainless steel, brass, bronze, copper, nickel, nickel alloys, and carbon steels. Typical applications are food and dairy equipment, instruments, oxygen lines, sanitary apparatus, and general maintenance repair.

TECHNICAL DATA:

Tensile Strength..... up to 15,000 psi (103 N/mm²)
Working Temperature 430°F (221°C)
Hardness (HB) 15
Color Match excellent on stainless steel
Corrosion Resistance good
Diameter (in) 1/32" 1/16" 3/32" 1/8" 8oz.
(mm)0.8 1.6 2.5 3.25 Paste

PROCEDURE:

Clean joint area. Apply the flux and heat parts with a soft flame being careful not to burn the flux. Apply solder and continue heating until flowout is complete. Add additional flux if necessary while solder is still molten. When using 2012 paste solder, paint joint area before assembly. Put parts together and heat until alloy becomes liquid. Allow to cool slowly and wash flux residue off with warm water.