

Brazing Alloys for Maintenance on Steel Products

BF-1(0386-0422)

BronzeFlow (for steel materials other than stainless steel - available in 1 lb. package) Brazing range 1595-1620°F (868-882°C) for low fuming bronze. Ideal for maintenance repairs on plumbing and heating. Tensile strength - 63,000 psi. Meets AWS A5.8, ASTM B-259, Federal QQR571B, MIL-R-19631B specifications.

NS-1(0386-0431)

NicSil-Flow (for stainless steel and chrome-plated products) Nickel content brazing rod. Low fuming type nickel-bronze alloy. Brazing range 1665-1680°F. Tensile strength - 70,000 psi. Meets AWS A5.8, ASTM B-259, Federal QQR571B, MIL-R-19631B specifications.

Silver/Copper/Phosphorus Brazing Alloys

SF-1(0386-0421)

SF-2(0386-0493)

SF-5(0386-0494)

SF-6(0386-0495)

SS-15(0386-0491)

Aluminum Brazing Alloy

AK-1(0386-0423)

Aluminum brazing alloy rod and flux for aluminum products, even anodized aluminum. Ideal for refrigerant coil and tubing repair. Kit includes rod and self-cleaning flux.

MODEL NUMBER	SILVER CONTENT	CHEMICAL COMPOSITION	SPECIFICATIONS	TEMPERATURES LIQUIDUS/SOLIDUS		TYPICAL APPLICATIONS
SF-1 1 lb.	0%	0% Silver 7.1% Phosphorus Balance Copper	AWS A5.8 BCuP-2 QQB-650B	1500°F 816°C	1350°F 732°C	• Moving joints • Non-moving joints • T-joints, swage joints, sleeves • Coupling on return bends and condenser fittings • Extending copper tubing and pipes • Flexible pipe connectors • Refrigeration control valves (copper and brass) • Joining copper wires to rotor bars • Building up control valves • Electrical Connectors • Radiant heating systems • Air conditioning units • Hot and cold water lines • Steam systems • Heat exchanges • Copper Joints
SF-2 1 lb.	2%	2% Silver 7% Phosphorus Balance Copper 0.15% All Other	AWS/A5.8 Class BCuP-6 QQB-650C Class BCuP-6	1450°F 788°C	1190°F 643°C	
SF-5 1 lb.	5%	5% Silver 6% Phosphorus Balance Copper 0.15% All Other	AWS/A5.8 Class BCuP-3 ASMESFA5.8 Class BCuP-3 QQB-650B Class BCuP-3	1500°F 816°C	1190°F 643°C	
SF-6 1 lb.	6%	6% Silver 6.5% Phosphorus Balance Copper 0.15% All Other	_____	1425°F 774°C	1190°F 643°C	
SS-15 1 lb.	15%	15% Silver 5% Phosphorus Balance copper	AWS A5.8 QQB-650A MIL-E-15395A	1465°F 796°C	1190°F 643°C	

Note: .45 kg per pound, 11.34 kg equals 25 lbs