

AMTEC 1005 FC 56% FLUX COATED SILVER BRAZING
JOINING ALLOY FOR USE WITH TORCH

General Characteristics

Amtec 1005 FC is a unique, ultra high purity 56% silver brazing alloy with a super active flux that contains twice the base metal cleansing action of conventional silver flux coated alloys. The flux coating is designed to be flexible and non-fragile and permits less odor than normal silver alloys. Amtec 1005 FC is the only silver solder with a flux that is strong enough to clean oxidized stainless steel. Because this alloy contains no cadmium, it is widely used on food and beverage handling equipment.

Procedure

Clean the weld zone of all contaminants. Preheat the general area to 350°F, then heat the joint area to 800°F. Melt off some flux and allow it to flow throughout the joint. Then add the silver alloy and using the flame of the torch pull the molten alloy through the joint. Keep adding alloy as required to fill joint. The alloy has very good capillary action and will flow very easily throughout the joint area to form a very strong bond.

Application

Amtec 1005 FC is excellent for close fitting joints in the food, medical and pharmaceutical industries. This product can be used on steel, copper, stainless steel, and other ferrous metals except for the white metals. Amtec 1005 FC is also excellent for repair of electronic and mechanical equipment, and other delicate parts.

Tensile Strength	71,000 PSI
Yield Strength	60,000 PSI
Elongation	25%
Hardness	130 Brinell
Electrical Conductivity	14.3
Melting Point	1210°F
Working Temperature	1140-1200°F

Diameter (Inch)	3/64	1/16	3/32
(mm)	1.2	1.5	2.5

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Subject to change without notice

Orange or Pink Flux Coating
18 Inch Rod