



## **AMTEC 1006 FC 45% FLUX COATED SILVER BRAZING JOINING ALLOY FOR USE WITH TORCH**

### **General Characteristics**

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Amtec 1006 FC is a unique, ultra high purity 45% 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 1006 FC is the only silver solder flux that is strong enough to clean oxidized stainless steel. This alloy is great for low temperature joining of dissimilar metals, and is excellent where tolerances and fit are not perfect.

### **Procedure**

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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**

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Amtec 1006 FC is excellent for use as a joining alloy on applications requiring a free flowing low temperature silver solder. This alloy can be used to join similar and dissimilar metals such as carbon and alloy steel, copper, stainless steel, nickel, brass, bronze, monel, inconel, and for attaching carbide tools. Excellent on light gauge metals.

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<b>Tensile Strength</b>	<b>68,000 PSI</b>
<b>Yield Strength</b>	<b>54,000 PSI</b>
<b>Elongation</b>	<b>25%</b>
<b>Hardness</b>	<b>120 Brinell</b>
<b>Electrical Conductivity</b>	<b>13.5</b>
<b>Melting Point</b>	<b>1245°F</b>
<b>Working Temperature</b>	<b>1175-1235°F</b>

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<b>Diameter (Inch)</b>	<b>1/16</b>	<b>3/32</b>
<b>(mm)</b>	<b>1.5</b>	<b>2.5</b>

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