



AMTEC 1050 FC NICKEL SILVER BRAZING

BUILD-UP ALLOY FOR USE WITH TORCH

General Characteristics

Amtec 1050 FC is a unique ultra high purity nickel silver alloy with a special flux coating that eliminates harsh chemical odors and the bright glare that conventional type nickel silver normally offers. It has a slick, smooth moisture sealed flux that has triple the life of normal products of the same type. The flux cleaning action is exceptional on dirty steels and cast irons. The difference with the 1050 FC is that it has the ability to build-up more than thin flow, so it is excellent for building up and overlaying of parts that need a wear resistant surface.

Procedure

Clean the weld zone of all contaminants. A rough ground surface will produce the best results. This flux coated alloy does not need extra flux and will break down tough oxides that normally form. Always use a neutral flame concentrating on the base metal and not the rod. Keep the torch in constant motion to prevent overheating of local areas. When using this product as a build-up alloy, use the largest size, which will help build up quickly. Make sure that the alloy has fused with the base metal and then begin to build up to the desired size and shape. This alloy can be flame shaped to help eliminate machining. Allow part to cool slowly when done, and remove flux with a stainless steel wire brush.

Application

Amtec 1050 FC is excellent for overlaying and build-up of gear teeth, bearings, shafts, valve seats, wedge bars and steering knuckles. This alloy can be used to build-up carbon steel, alloy steel, cast iron and many nonferrous alloys, such as brass, bronze and copper.

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|---------------------------------|--|--------------------|
| Tensile Strength | | 113,800 PSI |
| Yield Strength | | 95,000 PSI |
| Elongation | | 28% |
| Hardness | | 210 Brinell |
| Hardness (Work Hardened) | | 265 Brinell |
| Melting Point | | 1583-1640°F |
| Working Temperature | | 1595°F |
| Remelt Temperature | | 1800°F |

| | | |
|------------------------|-------------|-------------|
| Diameter (Inch) | 1/8 | 3/16 |
| (mm) | 3.25 | 5.0 |

CONFIDENTIAL INFORMATION
Subject to change without notice

Pink Flux Coating
18 Inch Rod