

TECHNICAL DATA SHEET

Starweld 856 FC

SILVER ALLOY

Description :

Cadmium-free universal coated rods with very high silver content for brazing ferrous and non-ferrous metals, steels, stainless steels, copper and nickel alloys.

Silver content (Ag) : 56%

Characteristics :

- **Conforms to standard : AWS A5.8 : BAg-7**
- Very high capillarity
- Exceptional corrosion resistance
- Excellent electrical conductivity
- Good colour match with stainless steel
- Low bonding temperature

Mechanical properties :

- Tensile strength : 80 000 psi (550 MPa)
- Bonding temperature : 570 - 620°C (1060 - 1150°F)

+ **Diameter**

1.6 mm

2.5 mm

+ **Carburizing flame**

Applications :

Ideal for joining and repairing stainless steel equipment used in food and dairy industries. Excellent for high vacuum assemblies, laboratory apparatus, tubes, instruments, high pressure fittings, hospital equipment, refrigeration, etc.

Procedure :

Clean the brazing area by removing grease and dirt, melt a little flux at the end of the rod and continue heating until the flux becomes liquid. Using indirect heat, melt the alloy in the joint. Allow to cool slowly and remove residual flux by soaking in water. Use a carburizing flame.

Also available in 6 rods kits : Starweld 856K

1 800 361 9097

