



Turbine Blades

High silver brazing alloy with excellent fluidity for brazing narrow clearance joints

Typical Applications:

Instruments, high-speed tools, dies, carbide tipping, thin tubing, wire mesh, electrical contacts.

Outstanding Features:

- High degree of wettability.
- Low melting.
- Very high strength joints.
- Extremely thin flowing.
- Especially for dissimilar combinations.

Recommendation:

An extremely versatile low melting alloy with excellent wettability for thin flowing applications on copper, nickel, carbon and alloy steels, carbides and stainless steel. Ideal for lap, T' flange and square butt joints of dissimilar metals. Excellent for delicate parts, light gauge metals and heat treated parts. Use with furnace, induction equipment or oxy-acetylene torch.

Procedure:

Clean joint area. Paint EWAC BR 650 flux on the rod and on the joint. Heat broadly, using an excess acetylene flame, until flux liquefies. Flow alloy completely through the joint. Cool slowly and remove flux residues.

Recommended Amperages:

ROD	Shim
1.6	25 x 0.075
3.2	25 x 0.075

Bonding Temperature: 600° C

Tensile Strength: 63 Kg/mm² (90,000 psi)