



HI-ALLOY 1000

ECONOMICAL, HIGH SILVER CADMIUM BEARING BRAZING ALLOY

DESCRIPTION: Hi-Alloy 1000, like the 1200 alloy, is a free flowing cadmium bearing alloy for general purpose industrial use. Its lower silver content makes the 1000 more economical, and the chemical variations give it a broader melting range making it suitable for looser fitting joints.

TYPICAL APPLICATIONS: Joining stainless steels, carbon steels, copper alloys, nickel alloys, and dissimilar combinations of these metals. Useful for fabrication and repair of machine parts, hydraulic lines, gas or pressure lines, assembly of scale models and prototypes.

PROCEDURES: Prepare the work area by chemical or mechanical cleaning, maintain a joint clearance of .005" maximum, apply Hi-Alloy Sil Squeeze or Hi-Alloy Ultra Crème flux to the joint area, heat the parts broadly and uniformly with a neutral to slightly carburizing flame. When the flux turns clear and flows through the joint apply the 1000 alloy and it will follow the flux filling the joint. Allow the part to cool slowly in still air. Remove flux residue with hot water and a stainless steel brush.

AVAILABLE SIZES: 1/16 3/32 Both in 18" Lengths

TENSILE STRENGTH: Up to 59,000 psi

ELONGATION: Up to 22%

BRAZING TEMPERATURE: 1295° - 1550° F