



HI-ALLOY 1200FC & 1200 BARE

HIGH SILVER, CADMIUM BEARING BRAZING ALLOY

DESCRIPTION: Hi-Alloy 1200 alloy is a thin flowing, high strength, alloy for general purpose low temperature industrial brazing. The addition of cadmium provides for exceptional wetting and capillary action, making this alloy an excellent choice for use on intricate parts, thin metals, and tight fitting joints. The highly active flux on the 1200FC provides excellent oxide neutralization, acts as a temperature indicator, and helps keep work areas clean.

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 .003" maximum, heat the parts broadly and uniformly with a neutral to slightly carburizing flame, heat the flux coated rod and apply drops of the flux to the joint area, (when using 1200 Bare rod apply Hi-Alloy Sil Squeeze or Ultra Crème flux). When the flux turns clear and flows through the joint apply the 1200 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: 1/32 (Bare Only) 1/16 3/32 All in 18" Lengths

TENSILE STRENGTH: Up to 53,000 psi

ELONGATION: Up to 22%

BRAZING TEMPERATURE: 1125° - 1400° F