



## **HI-ALLOY 1300PD**

### **HIGH SILVER CADMIUM FREE BRAZING PASTE**

**DESCRIPTION:** Hi-Alloy 1300PD is a Cadmium Free, high silver brazing alloy in paste form. Fine particles of the silver alloy are suspended in a fluxing binder so no messy pre-fluxing is necessary. This alloy simplifies the process of brazing most metals including brass, nickel, copper, steel, and stainless steel. It is not, however, for use on aluminum, magnesium, or white metal.

**TYPICAL APPLICATIONS:** This product can be used in any application where conventional silver brazing alloy wires could be used. Since it is cadmium free it may also be used on medical instruments, and for fabrication and repair of products used in the food and dairy industries.

**PROCEDURES:** Carefully clean and degrease the surfaces to be brazed, prepare a tight fitting joint, apply 1300PD to the joint area and press the parts together squeezing the paste throughout the joint leaving a visible bead on the outside edges, adjust torch to a neutral flame, keep the torch moving to prevent hot spots, apply heat to the perimeters of the joint but not directly on the joint, after you see the alloy begin to flow, concentrate heat on the joint for a moment to insure all the alloy is melted. Remove flux while still warm by immersing the part in hot running or agitated water. Use a stainless steel brush to remove stubborn residues.

**AVAILABLE SIZES:** 2 oz. Syringe Dispenser or 1 lb Jar

**MELTING TEMPERATURE:** 1145° - 1205° F

**TENSILE STRENGTH:** Up to 70,000 psi