



HI-ALLOY 1300FC & 1300 BARE

HIGH SILVER, CADMIUM FREE BRAZING ALLOY

DESCRIPTION: Hi-Alloy 1300FC has a unique, ultra active, fast flowing flux, potent enough to clean oxidized stainless steel. This special flux provides a clear, clean path through tight fitting joints for the 1300 alloy to freely flow assuring complete wetting of all surfaces. Another feature of this flux is its ability to be bent without breaking off of the rod enabling you to reach the alloy into awkward places.

TYPICAL APPLICATIONS: This F. D. A. approved alloy may be used for applications involving the medical, food, dairy, and pharmaceutical industries, as well as any other application where the use of cadmium bearing products is prohibited. It easily joins stainless steels, copper alloys, carbon steels, nickel alloys, and dissimilar combinations of these metals.

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 melted flux to the joint area, (when using 1300 Bare rod apply Hi-Alloy Sil-Squeeze or Ultra Crème flux). When the flux turns clear and flows through the joint apply the 1300 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 76,000 psi

ELONGATION: Up to 22%

BRAZING TEMPERATURE: 1205° - 1400° F