



HI-ALLOY 1400

CADMIUM AND NICKEL BEARING HIGH SILVER BRAZING ALLOY

DESCRIPTION: Hi-Alloy 1400 is a multipurpose silver brazing alloy containing cadmium to lower the melting temperature, and nickel to increase corrosion resistance and improve wettability on tungsten carbide parts. Its lower fluidity makes this alloy suitable for making larger fillets or filling wider joint clearances.

TYPICAL APPLICATIONS: Repair and fabrication of assemblies made from steel, stainless steel, nickel, nickel alloys, copper, copper alloys or any combination of these metals. It is widely used to braze tungsten carbide tool tips and assemblies and may be used on parts used in a marine environment or parts subject to caustic media.

PROCEDURES: Prepare the work area by chemical or mechanical cleaning; fit the parts to .002" to .005" joint clearance. 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, melt off an adequate amount of the 1400 rod and continue heating broadly until the alloy flows through the entire joint area. Allow 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 70,000 psi

ELONGATION: Up to 22%

BRAZING TEMPERATURE: 1270° - 1500° F