



HI-ALLOY 15FC

HI-STRENGTH NICKEL SILVER BRAZING ALLOY

DESCRIPTION: Hi-Alloy 15FC was designed for joining most ferrous and non ferrous metals, cast irons, steels, stainless, nickel alloys and copper based alloys. It is also superior for joining dissimilar metal combinations with the exception of aluminum and the white metals. The deposits are fully machinable and posses excellent corrosion resistance at normal and elevated temperatures. 15FC may also be used as a build-up or cushion layer prior to hardfacing.

TYPICAL APPLICATIONS: Fabrication or repair of bicycle frames and tubular steel furniture, repairing cast iron castings, overlay and joining of steels, nickel alloys, stainless steels, copper based alloys and dissimilar combinations of these metals.

PROCEDURES: Clean or grind the base metal. Bevel heavier sections. Preheat broadly to 900° F. Concentrate heat in the joint area to 1300° F. Melt a small amount of flux from the rod onto the joint area and continue heating indirectly until the flux turns clear and flows. Apply the 15 alloy, continue to heat and add alloy as needed to complete the procedure. Allow finished part to cool slowly in still air. Remove flux residues with hot water and a stainless steel brush.

SIZES AVAILABLE: 3/32 1/8

BRAZING TEMPERATURE: 1720° - 1800° F

TENSILE STRENGTH: Up to 70,000 psi

HARDNESS: Up to 120 Brinell