HI-ALLOY 17FC

ULTIMATE HIGH STRENGTH BRAZING ALLOY

DESCRIPTION: Hi-Alloy 17FC is an excellent choice for high strength joining, overlay, or buildup of all ferrous and nonferrous metals except aluminum and the white metals. By making slight adjustments in procedure you can make this alloy flow out thin to braze tubing or buildup bead over bead to restore a broken gear tooth. This alloy also has outstanding resistance to frictional wear. The special flux coating on this product reduces the bright orange glare commonly encountered with conventionally coated brazing products that reduces visibility.

TYPICAL APPLICATIONS: Repair of cast iron castings, broken drill bits, damaged cutting tools, and broken gear teeth, carbide tipping, joining steels, copper alloys, nickel alloys, cast irons, and dissimilar combinations of these materials, overlaying steel surfaces subject to metal to metal wear.

PROCEDURES: Clean the area to be brazed, bevel sections over 1/8", adjust torch to neutral flame and hold flame cone close to the joint area. Preheat to 1500° F. Melt a small amount of flux from the rod onto the joint area and continue heating indirectly until the flux turns liquid and flows. For thin flow continue concentrating heat and add additional flux with the filler rod. For buildup, back off heat and turn flame away from molten metal heating just enough to melt the filler rod onto the previously deposited metal. Allow finished part to cool slowly in still air. Remove flux residues with hot water and a stainless steel brush.

AVAILABLE SIZES:	3/32 1/8
BRAZING TEMPERATURE:	1583° - 1640° F
TENSILE STRENGTH:	Up to 100,000 psi
HARDNESS:	Up to 200 Brinell