



HI-ALLOY 23FC

ULTIMATE LOW TEMPERATURE, LOW FUMING, FLUX COATED BRAZING ALLOY

DESCRIPTION: Hi-Alloy 23FC was formulated as a universal high strength alloy for brazing of all metals except aluminum and white metals. Its low working temperature reduces distortion and buckling of thin metal and allows for brazing of galvanized steels without damage to the coating. Fast freeze action makes it ideal for vertical and overhead brazing. Low smoke emissions help keep the fumes in the work area to a minimum.

TYPICAL APPLICATIONS: Fabrication or repair of copper based alloys, nickel alloys, steels, galvanized steels, cast irons, malleable irons, and dissimilar combinations of these metals.

PROCEDURES: For best results the joint area should be cleaned thoroughly. For temporary repairs in the field, clean parts as best you can. Cracks or heavy parts should be beveled. Adjust torch to a neutral flame, preheat parts broadly to 1600° F (metal should be a dull red). Melt a small amount of flux from rod onto the joint area and continue to heat indirectly. When flux turns clear and flows add the 23 alloy, continue to heat and add flux and alloy as needed to complete the procedure.

AVAILABLE SIZES: 3/32 1/8

BRAZING TEMPERATURE: 1670° - 1750° F

TENSILE STRENGTH: Up to 65,000 psi

HARDNESS: Up to 96 Brinell