



# TBW 5056

## SILVER ALLOY

### DESCRIPTION

Seamless, tubular flux-cored cadmium-free brazing product with a very high silver content for brazing ferrous and non-ferrous metals; steel, stainless steel, nickel and copper alloys.

### CHARACTERISTICS

- Conforms to specifications AWS A5.8: BAg-7
- No extra flux required
- No fragile coating
- Quick and easy application
- Longer shelf life of the product
- Reduction of the heat contribution compared to the solid cored rod
- High fluidity and good wettability
- Easy and less cleaning after brazing
- Ratio metal/ flux: 88/12

### TYPICAL APPLICATIONS

Ideal for joining and repairing stainless steel equipment used in food and dairy industries. Excellent for high vacuum assemblies, laboratory apparatus, tubes, instruments, high pressure fittings, hospital equipment, refrigeration, etc.

### PROCEDURE

Clean the section to be brazed by removing grease and dirt. Heat the rod tip to pulverize liquid flux on the part and to continue to heat until the flux becomes liquid. Cool slowly and remove flux residue by plunging into water. Use a slightly carburizing flame.

### MECHANICAL PROPERTIES

Tensile strength: 80 000 psi (550 MPa)

### BRAZING PARAMETERS

Diameter: 2.0 mm (5/64") 1.6 mm (1/16")  
 Bonding temperature: 620 - 655°C (1148 - 1211°F)  
 Type of flame: Slightly carburizing

Rod available in 0.5 kg tube and 6 rod kits, also in coil of 1 kg.

Also available: Flux coated rod: **Soudotec 6020 FC**, bare rods: **Soudotec 6050B**, coil: **Soudotec 6050C**, and shim: **Soudotec 6050S**. (Use with flux **Soudotec F060**)

For carbide brazing, use sandwich shim with cadmium: **Soudotec 6047 SS** and without cadmium: **Soudotec 6048 SS**, available upon request.

Rév.: 21\_08

*Specialized welding alloys and technology. For technical assistance or for ordering:*