



6157

SILVER ALLOY

DESCRIPTION

High-strength solid wire made up of a tin-silver alloy for **soldering** ferrous and non-ferrous metals; steels, stainless steels, copper alloys and nickel alloys **at low temperatures**.

CHARACTERISTICS

- Does not contain any contaminant (cadmium, lead, antimony, etc.)
- High fluidity
- Deposits are shiny and suitable to plating
- Good conductivity
- Good color match on stainless steels
- Good resistance to corrosion and vibrations
- Reduced risk of deformation

TYPICAL APPLICATIONS

Ideal for brazing thin sections; printed circuits, boilers, tanks, instrumentation; suitable for the food industry, hospitals, breweries, dairy plants, sugar refineries, etc.

PROCEDURE

Clean the brazing area and remove grease and dirt. Apply **Soudotec F061**. Heat the joint indirectly until the flux reaches the boiling stage. Apply the alloy on the joint and heat all around until it flows in the joint. Wash out the flux residues with warm water. Use a low carburizing flame.

MECHANICAL PROPERTIES

Tensile strength: 15 500 psi (106 MPa)

BRAZING PARAMETERS

Diameter:	3.2 mm (1/8")	1.6 mm (1/16")
Bonding temperature:	195°C (385°F)	
Type of flame:	Low carburizing	
Packaging:	500 gram spool (0.5 kg)	

Also available: Soldering paste in syringe: **Soudotec 657P**

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Produits et techniques de soudage spécialisé. Pour assistance technique ou pour commander :