

ISO
9001:2000
Certified

SILVER BRAZING ALLOYS, SOLDERS & FLUXES



SIL-CAN Silver Brazing Alloy

SIL-CAN comes in all standard formulations to suit many brazing applications. All SIL-CAN Brazing Alloys meet applicable military and government specifications. Available in stick, rod, wire, performs and rings. We also produce brazing flux and ACTION TIN, a proprietary tinning paint available in tin/lead and LEAD-FREE formulations.

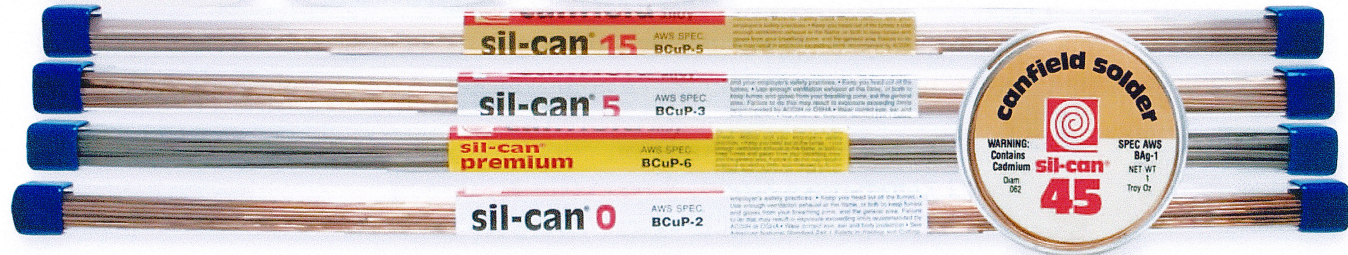
SIL-CAN 0: Extremely fluid, economical alloy for close fitting joints with clearances from .001 to .003. It is self-fluxing on copper and contains no silver. Brazing temperatures 1350°F to 1550°F.

SIL-CAN PREMIUM: Ductile, fluid alloy for economical torch or induction brazing. Works well on joint clearances from .001 to .005. Similar to SIL-CAN 0 but lower brazing temperature and better melting makes it easier to use. Brazing range 1300°F to 1550°F.

SIL-CAN 5: More economical than SIL-CAN 15, with a slightly higher melting range. It's a tough ductile alloy for brazing on average joint clearances. Conforms to ASTM BcuP-3 and contains 5% silver. Brazing temperature is 1300°F.

SIL-CAN 15: Most widely used and easiest to use silver brazing alloy for copper and copper alloys, combining the highest ductility with the lowest brazing temperatures. It is used when close fit-ups cannot be maintained, and is self-fluxing on copper to copper joints. Ideal on air conditioners, radiators, electrical connections, etc. Contains 15% silver. Brazing temperature is 1300°F. (Copper alloys such as brass and bronze need SIL-CAN WHITE CREAM BRAZING FLUX.)

SIL-CAN 35: For use on steel and all ferrous and non-ferrous metals. An excellent alloy for torch-brazing where fit-up is poor to average and large fillets are required. Almost the same strength as SIL-CAN 45. Contains 35% silver and has a



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brazing temperature of 1250°F to 1300°F. Use SIL-CAN WHITE CREAM BRAZING FLUX for SIL-CAN 35.

SIL-CAN 45: Most popular brazing alloy for brazing steel, stainless steel, copper, copper alloys, and nickel and its alloys. Free-flowing with excellent strength for average to good fit-ups. Contains 45% silver. Brazing temperature is 1175°F. Use SIL-CAN WHITE CREAM BRAZING FLUX.

BRAZESAFE 45: Cadmium free brazing alloy for silver brazing without toxic fumes. Free flowing with similar characteristics and uses as SIL-CAN 45, but requires a somewhat higher brazing temperature (1300°F). Use SIL-CAN WHITE CREAM BRAZING FLUX.

BRAZESAFE 56: Cadmium free alloy with the lowest brazing temperature (1200°F) of this class of alloys. Excellent choice for use in food handling equipment and hand torch brazing. While good for brazing all ferrous and non-ferrous alloys, its whitish color makes it a good color match for certain stainless steels and sterling silver.

SIL-CAN Solder

LEAD-FREE EVERGLEEM 496: Tarnish resistant silver/tin solder of exceptional strength and ductility. Although it melts at 430°F, it has exceptional strength vibration resistance at 250°F. Contains no antimony, NO LEAD or other toxic metals, meets all sanitary code requirements for food equipment, stays bright, and maintains its color on stainless steel. Used on potable water systems, low pressure steam, radiators, etc. Meets ASTM Specification B32 and J-STD-006, Sn96. (Use SIL-CAN LIQUID SOLDERING FLUX when soldering stainless.)

SIL-CAN Fluxes

SIL-CAN WHITE CREAM BRAZING FLUX: A general purpose, homogenized brazing flux for use with the above silver brazing alloys when required. Fully active between 1100°F and 1600°F, making it suitable for 95% of all brazing jobs. For both torch and induction heating. Meets Federal Specification O-F-499C and AMS341OD.

SIL-CAN LIQUID SOLDERING FLUX: Extremely active liquid flux uses with EVERLGLEEM 496 as well as regular solders especially on stainless and galvanized steel. Also suitable for use with torch, dipping and induction heating. Inorganic chloride residues are corrosive, but are easily removed with hot water.

Sil-Can Alloy	Nom. Comp. %				Temperature °F		AWS: A5.8-62 ASTM: B260-62T
	Ag	Cu	Zn	Other	Solidus	Liquidus	
Sil-Can 0	-	93	-	7 Phos.	1310	1480	BcuP-2
Sil-Can Premium	2	91	-	7 Phos.	1190	1450	BCuP-6
Sil-Can 5	5	89	-	6 Phos.	1190	1490	BCuP-3
Sil-Can 15	15	80	-	5 Phos.	1190	1475	BCuP-5
Sil-Can 35	35	26	21	18 Cad.	1195	1295	BAG-2
Sil-Can 45	45	15	16	24 Cad.	1125	1145	BAG-1
Brazesafe 45	45	30	25	-	1225	1370	BAG-5
Brazesafe 56	56	22	17	5 Tin	1145	1205	BAG-7

SIL-CAN Alloys meet appropriate Federal Spec. QQ-B-650a & QQ-B-654

SIL-CAN 0 - 15 have a specific gravity of approximately .30 lbs. per cubic inch.

SIL-CAN 35, 45, & BRAZESAFE have a specific gravity of approximately 5.0 troy ounces per cubic inch.

For more information contact us:

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