



# STRATA

SUPERIOR WELDING PRODUCTS



## STRATA 22F

### FLUX COATED 56% SILVER SOLDER - HIGH STRENGTH, EASY FLOWING, CADMIUM FREE

**USAGE:** 56% FC silver for high-strength low-temperature joints in the food, medical and pharmaceutical industries. Super active cadmium-free flux provides twice the cleansing action of conventional silver flux. Excellent for bonding all steel, stainless, brass, bronze, copper alloys, tungsten carbide, cast iron, cast steel, chrome-moly & gold.

- Rare flux coated silver rods for precision work.
- Special "Fast Flow" flux coating provides twice the base metal cleansing action of conventional silver flux coatings.
- No odours from rubberized compounds yet the flux coating is totally flexible and non-fragile.
- The only flux coated silver flux strong enough to clean oxidized stainless steel.

#### ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Flux Colour:** Pink or custom colours

Ag	Cu	Zn	Sa
56	22	17	5

#### TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up To
Tensile Strength	71,000 PSI (490 MPa)
Yield Strength	60,000 PSI (415 MPa)
Elongation	25%
Conductivity	14.3
Density	9.59/cm <sup>3</sup>
Hardness	Brinell 130

AWS/ASME A5.8 BAg-7



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### TEMPERATURE RANGES

Working Temperature	Liquidus	Solidus
1210°F (655°C)	1200°F (650°C)	1140°F (620°C)

### BRAZING INSTRUCTIONS

**Welding Techniques:** Thoroughly clean area to be joined or repaired. Using a carburised flame, heat work area broadly until flux becomes clear and fluid. Melt a small part of the alloy onto the joint and continue heating until alloy wets out and fillet has formed on both sides of the joint. By keeping the torch in constant motion, the alloy will follow the heat of the flame. Allow part to cool slowly and remove flux residue with warm water.

**Torch Setting:** Slightly carburising

### DEPOSITION RATES

Diameter (mm)	Length (mm)	Weldmetal/ Rod	Joint Length/1" (25mm) of Rod
1/16 (1.6)	18" (450)	.33oz (9.2g)	24" (600mm)

### APPROXIMATE ROD PACKAGING & DIMENSIONS

Diameter (mm)	1.6mm (1/16")
Length (mm)	457mm (18")
Rods/lb	32
Rods/kg	70
Feet/lb	48
Cm/kg	3150

### ORDERING INFO

Diameter	Pack Size	Product Code
1.6mm	Per Rod	#39584
1.6mm	1KG	#202151

