

# ARCTEC® 1004 FC SILVER BRAZING ALLOY



## GENERAL CHARACTERISTICS:

ARCTEC® 1004 FC is a low melting, free flowing flux coated silver brazing alloy for use as a joining alloy where free flowing characteristics are required. This alloy has good electrical conductivity and excellent color match on stainless steel.

## APPLICATIONS:

ARCTEC® 1004 FC is recommended for brazing a variety of metals such as stainless steel, copper, nickel alloys, brass, bronze and other nonferrous metal except aluminum and magnesium. For use on electrical appliances, food handling equipment and instrumentation.

## WELDING PROCEDURE:

Clean the weld zone free of all contaminants and remove surface oxides by brushing with a stainless steel or fibre brush. Heat area with oxyacetylene or propane flame. Add filler and continue heating until the alloy flows into joint. Flux residue may be removed using hot water and a brush.

## MECHANICAL PROPERTIES:

\* Please Note: Tensile strengths of silver brazing alloys are not stated as several variables such as procedure used, material being soldered, joint design, fit up, etc. will affect the joint strength. Exact tensile strength values can only be determined by conducting test on the actual joint design utilized.

## OPERATING PARAMETERS:

WELDING PROCESS; OFW-TB

Melting Range  
680°- 740°C  
1260°- 1360°F

Available diameters:	Inch.	1/16"
	mm.	1.60

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