ARCTEC® 1018 FC FLUX COATED BRAZING ALLOY

a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® 1018 FC is a high strength, thin flowing, flux coated nickel braze welding alloy (called nickel silver). Produces high strength joints on practically all ferrous and non-ferrous metals except the white metals.

APPLICATIONS:

ARCTEC® 1018 FC is recommended for production and maintenance applications. Excellent for joining carbon and alloy steels, repairing broken drill bits, milling cutters, band saws and for brazing carbide tips to tool bits. Excellent for brazing of high pressure steel hydraulic fittings and elbows on construction equipment.

WELDING PROCEDURE:

Clean the weld zone free of all contaminants such as rust, grease, oil mill scale, etc.,. Heavy sections should be beveled to form a 90° V. Using a neutral flame preheat joint area. When base metal is a dull red color melt some flux off the end of the rod and continue heating until flux liquefies. Melt off a drop of alloy from the rod and continue heating until the alloy flows and bonds readily. Continue this process until the joint is filled. Multiple passes can be made without removing the excess flux between passes.

MECHANICAL PROPERTIES:

Tensile Strength	Up to 69,000 psi (475 Mpa)
Hardness:	150 to 200 HB

OPERATING PARAMETERS:

WELDING PROCESS; TB

Use neutral flame for brazing

Brazing Range

1720 to 1800 °F 938 to 982°C

Available diameters:	Inch.	1/8"	1/8"
	mm.	25.0 mm	3.25 mm

CALGARY FAX:(403)-250-7682	EDMONTON: (780)-484-4896	VANCOUVER: (604)-596-2940	WINNIPEG: (204)-663-7955
PHONE:(403)-250-9355	(780)-484-3304	(604)-596-6207	(204)-663-9182

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