ARCTEC® 1050 FC FLUX COATED BRAZING ALLOY

a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® 1050 FC is a nickel bearing, low fuming, flux coated braze welding alloy. This alloy produces deposits with high ductility, excellent corrosion resistance and good resistance to frictional wear. Has excellent machinability and good work hardening properties.

APPLICATIONS:

ARCTEC® 1050 FC is recommended for overlays and build up on surfaces subject to frictional wear, and ferrous and non-ferrous metal components where machinability is a factor. Used on parts such as worn shafts, gear teeth, pistons, planner guides, worn bearing and valve seats.

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. Flux removal between passes is not necessary.

MECHANICAL PROPERTIES:

Hardness: 150 to 200 HB

OPERATING PARAMETERS:

WELDING PROCESS; TB

Use neutral flame for brazing

Brazing Range
1670 to 1750 ºF 910 to 955ºC

Available diameters:	Inch.	1/8”	3/16”
	mm.	3.25	5.00

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