



Bare Brazing Rods
BRAS 3343

HIGH SILVER CONTENT ALLOY FOR MULTIPURPOSE BRAZING



ALLOY BASIS : Ag, Cu, Zn, Cd

KEY FEATURES :

- Very low melting silver alloy
- High Silver content of 43%
- Excellent flowing characteristics and capillary action

TYPICAL APPLICATIONS :

- Carbon steel, low alloy steels, tool steels, stainless steels
- Carbide tips, Cu and its alloys, Ni and its alloys and their dissimilar combinations
- Construction of apparatus, precision jobs, novelty articles, kitchen ware, surgical instruments, repairs of delicate components
- Production of precision tools, pharmaceuticals industry



HEAT SOURCE :

Oxy-Acetylene torch, Air-Gas torch, Blow lamp, Furnace

PROCEDURE :

Clean the joint thoroughly. Use neutral flame. Spread the flux in paste form on the joint. Dip heated rod into flux. Joint clearance should be approximately 0.1 mm. Preheat a broad area and then heat locally until flux melts. Continue heating joint area until the flux melts. Melt filler metal and draw with flame along the joint. Do not over heat.

CLEANING :

Remove flux residues by rinsing in hot water.

TECHNICAL DATA :

| Solidus Temperature | Liquidus Temperature | Brazing Temperature Range |
|---------------------|----------------------|---------------------------|
| 643°C | 802°C | 705-815°C |

PACKING DATA :

| Ø x L, mm | Kg/Plastic Tube |
|------------|-----------------|
| 1.60 X 500 | 5 |
| 2.50 X 500 | 5 |
| 3.15 X 500 | 5 |