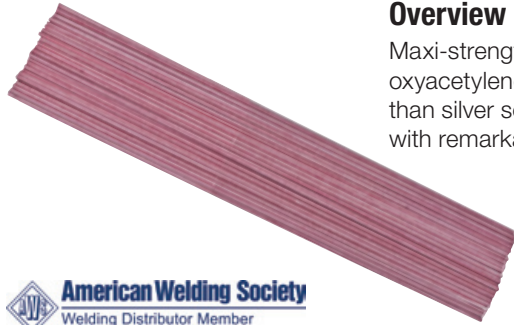


Technical Data Sheet

30F Brazing Alloy



Cronatron™
A LAWSON BRAND



Overview

Maxi-strength universal brazing alloy for all types of steels and copper-base alloys with oxyacetylene torch. This 100,000 PSI (689 MPa) super-strength alloy is 300% stronger than silver solder, yet it flows freely into the tightest joints or crevices and joins metals with remarkable bonding power.



Features/Benefits

- Ideally suited for rejoining broken drills, shaper blades and milling cutters
- Super free-flowing characteristics allow thin lapping and butted metal joining with dependable strength
- Performs equally well with cast iron, brass, bronze, nickel alloys and steels

Applications

- Industrial machines
- Machine shops
- Tool and die shops
- Mines and quarries
- Sheet metal shops
- Bicycle and motorcycle shops
- Truck maintenance

Method of Application

Oxyacetylene torch

Identification

Flux coated pink

Directions for Use

Clean joint area thoroughly. Heat metal with neutral flame until flux liquifies. Base metal should be dull red as 30F Brazing Alloy commences to penetrate the joint. Use rapid weaving motion with torch to deposit alloy drop by drop. Do not concentrate heat enough to melt base metal. Remove flux residue with water.

Technical Specifications

Tensile Strength: 100,000 PSI (689 MPa)
Temperature: 1,300°F to 1,600°F (700°C to 875°C)

Technical Tips

If additional flux is needed, F21 is recommended.

