Technical Data Sheet
41F Brazing Alloy

TDS

Cronatron™ A LAWSON BRAND

American Welding Society
Welding Distributor Member

Overview

41F Brazing Alloy is a specially formulated high-silver brazing alloy with DUO-FLO® action for economical, multipurpose use in general maintenance applications. Its DUO-FLO® alloy formulation makes it the most versatile and easy to use silver brazing alloy available.

Features/Benefits

- DUO-FLO® action allows alloy to thin-flow into the tightest joints and yet bridge gaps in poor fit joints
- Exceptionally low application temperature
- High strength and ductility
- Easy to use
- Outstanding results on ferrous, copper and nickel-based alloys

Applications

- General-purpose silver brazing
- Tee, lap or tubular joints
- Carbide tips
- Heat exchangers
- Tight or poor fit joints
- Dissimilar metal joining
- Electric rotors, contacts, lugs and terminals
- Tool repair
- Stainless steel equipment and piping

Method of Application

Torch

Identification

Red flux coating

Directions for Use

Remove all dirt and grease from parts to be joined. For maximum strength, joint clearance from 0.001" to 0.003" (0.025mm to 0.076mm) should be maintained. Using a slightly carburizing flame, heat broadly and rapidly. Melt a small amount of flux into joint area. When flux flows through joint, melt a small amount of 41F Brazing Alloy and draw it through the entire joint. Brazing operation should be rapid to reduce loss of built-in alloying elements.

Technical Specifications

Tensile Strength: To 80,000 PSI (552 MPa)
Melting Temperature: 1,120°F to 1,150°F (605°C to 620°C)

Technical Tips

Rapid and uniform heating of parts to be brazed provides superior results. When additional flux is required, F40 is recommended. Remove flux residue with warm water.