

# Technical Data Sheet

## 23F Brazing Alloy



*Cronatron™*  
A LAWSON BRAND



### Overview

Versatile flux-coated brazing alloy for brass-bronze-copper-cast iron-steel, galvanized and plated metals. Excellent for sheet metal and auto body repairs.



### Features/Benefits

- Low-temperature application reduces distortion on thin metals
- Can be painted without danger of bleed through
- No fumes
- Brazes through ordinary solders
- Leaves smooth, clean surface requiring minimal finishing
- Produces solid deposit with no porosity or pin holes
- Flows freely through thin cracks or tight joints yet is capable of bridging wider gaps and filling punctures and holes

### Applications

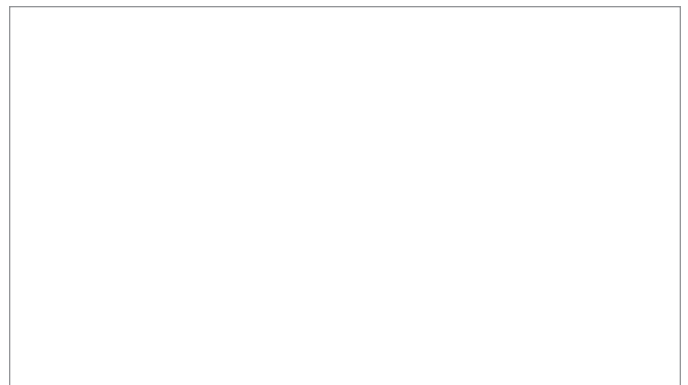
- Sheet metals
- Machine guards
- Hangers
- Braces
- Buildup of worn or missing sections
- Auto body sheet-metal repairs
- Gear housings
- Hoods
- Wire mesh
- Shafts

### Method of Application

- Torch

### Identification

- Blue flux coating



## Directions for Use

Joint area should be clean. Adjust flame to neutral and pre-heat broadly keeping the torch constantly in motion. For cast iron, sear the surface with an oxidizing flame prior to application. To apply alloy, concentrate heat at the start, then melt off some of the flux coating. As soon as fluxing action takes place, allow a drop of alloy to flow on to the work and continue heating until it wets out, then continue heating, adding additional alloy until the deposit is finished. If a second layer is required hold the torch flame parallel to the work and continue applying the alloy drop by drop. Flux residues need not be removed between passes.

When braze-welding cast iron, avoid excessive localized heating. When joint is completed, cover casting with dry, heat-resisting material to retard cooling.

## Technical Specifications

- Tensile Strength: 66,000 to 68,000 PSI (455 to 469 MPa)
- Temperature: 1,400°F to 1,600°F (760°C to 871°C)

## Technical Tips

If additional flux is needed, F21 is recommended.