## **11FC**

## FLUX COVERED ALLOY. "NICKEL-SILVER" STRONG WELD TYPE. HIGH RESISTANCE TO TENSION, FRICTION AND TORSION. IDENTIFICATION: BLUE COATING

**APPLICATIONS**: This is a special low fusion temperature alloy to weld all kinds of steel, copper alloys and nickel. It has top resistance to tension. Its flow is clean and easily controlled. This allows to do all kinds of restoration jobs. Filler metal is pore free. Even in thin layers, its adherence is outstanding so parts can be easily machined, including transition areas with the base metal. This alloy has a good friction coefficient. It withstands wear and corrosion and it is specially recommended for damaged and worn out parts and surfaces. It is used to recondition motor shafts, gear teeth, rail guide rollers, bearing pedestals and to prepare surfaces for PERFOR BAR welding.

**CHARACTERISTICS**: 11FC can replace all standard welds in bronze, steel and cast iron. It is used with oxyfuel gas torches in production and in maintenance work. It allows to join about fourteen different kinds of metals. It can also be used as an economic alternative to silver based strong welds in tool repair with high alloy steel. It is used to weld tool tips when the base metal can be heated up to 950 °C.

**PROCEDURE**: Clean the areas to be joined. When cladding cast iron with this filler metal, the surface has to be degreased by burning the oily residues. Then, coat the area to be joined with Vilchis Bronsil flux and preheat the base metal evenly and well beyond the joint area. Choose the lowest possible temperature for application. As soon as the flux melts down with the gas torch heat, start depositing the filler metal. Do not let the base metal preheat to a dark red hue. Point the torch nozzle towards the alloy and wave the torch about three centimeters wide for the alloy to flow and take. Keep the flame about ten milimeters away from the welding rod tip. Tilt the torch a little to avoid overheating the part. Let the part cool down.

HEAT SOURCE:	OXYFUEL GAS TORCH
RESISTANCE:	8900 Kg/cm2 (126000 PSI)
ELONGATION:	32%
WORKING TEMPERATURE:	DE 800 A 950 °C
FLAME SETTING:	NEUTRAL
MACHINING PROPERTIES:	EXCELLENT
AVAILABLE SIZES:	1/16" (1.6MM) - 3/32" (2.3MM) - 1/8" (3.2MM)