

AG-35FC

SPECIAL SILVER TYPE ALLOY, WITH FLUX COVERING. MULTIPURPOSE PRODUCT FOR FERROUS AND NON FERROUS METALS. EXCELLENT FLOW PROPERTIES DUE TO ITS CAPILLARITY

IDENTIFICATION: WHITE COATING

APPLICATIONS: For fine flow applications in alloy and carbon steel, stainless steel, tungsten carbide, copper and copper alloys, nickel and nickel alloys. Excellent to restore bronze and brass cast parts, especially to fill in minute pittings. Ideal to restore tools, in those cases when it is necessary to join high speed steel parts which have been submitted to heat treatment while retaining their original hardness. Ideal for welding small parts together with little or no distortion at all. Perfect choice to join copper to beryllium parts and for applications in the production of refrigeration equipment since it meets the leakproof requirements when soldering copper pipes to carry "FREON" gas.

CHARACTERISTICS: Fine flow silver type alloy. WITH THIS WELDING ROD, IT IS NOT NECESSARY TO MELT THE BASE METAL. USE IT WITH THE LEAST POSSIBLE HEAT ON THE BASE METAL. Good corrosion resistance and good electrical conductivity. Ideal to weld metals which are different, with no distortion risks

PROCEDURE: Parts to be welded should be carefully degreased to allow the alloy to flow freely. Square butt or lap welds should have a 0.04mm - 0.08 mm gap (0.0015" to 0.003"), to attain maximum resistance. Dip the welding rod in VILCHIS S-200 flux and put some flux in the area to be welded, too, before beginning. Fix the parts to be welded with clamps if necessary. Heat well with a neutral flame. Keep the flame cone between 1" to 3" away from the base metal. Heat till the flux melts down. Moving the flame from side to side, let the alloy flow through the joint. A smooth fillet should result on each side. Let the part cool down and then remove the flow traces.

TENSILE RESISTANCE:	5,900 Kg/ CM 2 (84,000 PSI)
WORKING TEMPERATURE:	650° C
SPECIFIC GRAVITY:	9.29 Grs/Cm3
ELONGATION:	42 %
KIND OF FLAME:	NEUTRAL

FILLER METAL CHEMICAL ANALYSIS %				AVAILABLE SIZES
Ag	Cu	Zn	Cd	1.5 mm - 1/16"
35.0	26.0	21.0	18.0	2.4 mm - 3/32"
				3.2 mm - 1/8"