

Technical Data Sheet

44 Brazing Alloy The “Money Saver” Alloy



Cronatron™
A LAWSON BRAND



Overview

An ideal substitute for silver solder when brazing copper, bronze, brass and other copper alloys.



Features/Benefits

- High corrosion resistance
- Excellent electrical conductivity
- Requires no flux when used in joining copper-to-copper welds
- Smooth, fast-flowing action
- Low temperature application

Applications

- Electrical contacts, switches and wire
- Busbars, copper tubing and pipes
- Copper tanks, vats and brewery equipment
- Refrigeration and air conditioning repairs
- Copper buildup of worn or broken components
- Joining copper cable, wire or mesh

Method of Application

Torch

Identification

Round, silver finish

Directions for Use

Use a slightly carburizing flame to obtain a free-flowing bead. 44 Brazing Alloy does not require fusion of the base metal surface. On a copper-to-copper weld, no flux is required but with brass or bronze, flux is needed for a strong, sure bond. It is recommended that a 2" to 3" (5.1cm to 7.6cm) distance between the flame cone and the base metal be maintained for best results.

Technical Specifications

Tensile Strength: 42,000 PSI (290 MPa)
Temperature: 1,350°F to 1,550°F (730°C to 845°C)

Technical Tips

Do not use on ferrous metals, nickel or aluminum applications. 44 Brazing Alloy normally does not require additional flux when bonding copper-to-copper alloys. In some instances where additional flux is necessary, F40 is recommended.

