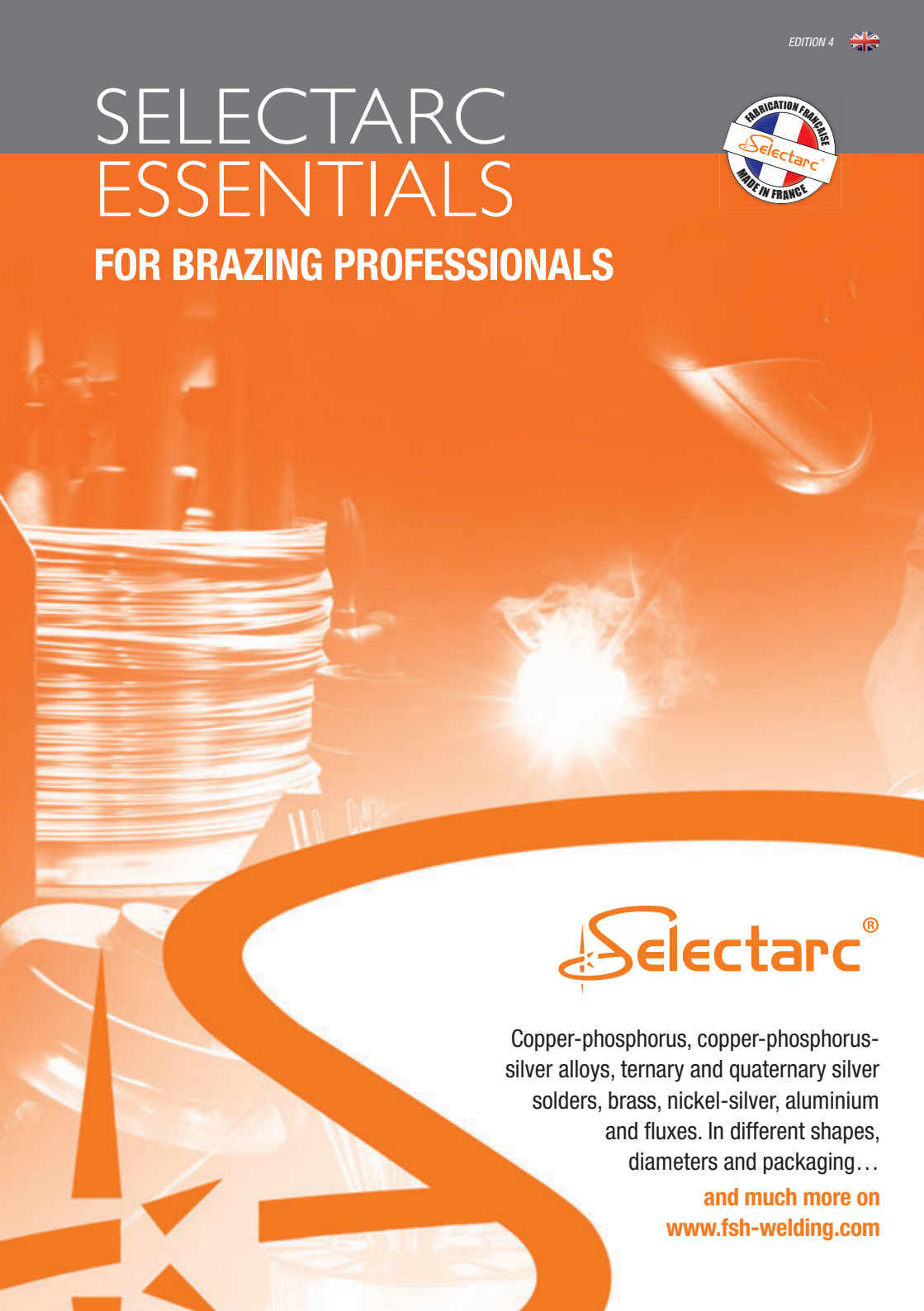
EDITION 4

SELECTARC ESSENTIALS

FOR BRAZING PROFESSIONALS



Selectarc®

Copper-phosphorus, copper-phosphorus-silver alloys, ternary and quaternary silver solders, brass, nickel-silver, aluminium and fluxes. In different shapes, diameters and packaging…

and much more on www.fsh-welding.com

FSH WELDING GROUP

INNOVATIVE WELDING CONSUMABLES

FABRICATION FRANÇAISE Selectarc MADE IN FRANCE

Innovation

Quality **Responsiveness**

Customization Flexibility

...

THE ONLY FOUNDRY OF BRAZING FILLER METALS IN FRANCE AND THE PIONEER OF COPPER-PHOSPHORUS ALLOYS!

FSH WELDING GROUP makes every effort to ensure that its customers fully benefit from its large know-how. Since 1948, Reboud-Roche, the brazing manufacturing division of the Group, has acquired recognised expertise, allowing it to be distinguished amongst the major players in the industry and distribution word-wide. The exceptionnal quality of its standard and tailor-made products, as well as its quality assurance process, guarantee the compliance with customer specifications.

Our products, sold under our brands SELECTARC WELDING and SELECTARC BRAZING meet strict requirements as far as quality and safety are concerned.

To achieve excellence is our goal, quality is in our genes and we reassert this motto every day.

PRODUITS D'APPORT DE SOUDAGE
WELDING FILLER METALS

Selectarc WELDING

PRODUITS D'APPORT DE BRASAGE
BRAZING ALLOYS

Selectarc BRAZING

WHAT IS BRAZING?

Brazing is a permanent metal-joining process which sets a metal continuity between close-fitting parts by capillary action. Brazing is an easy, economical, reliable and proven joining solution. Brazing allows joining metals of different types, such as: copper, brass, steel, stainless steel, aluminium, etc.

It is important to note that, unlike welding, there is no melting of base metals. Only the filler metal melt and flow over the base metal (wetting).

Brazing is widely used as an assembly technique in all industries and in building trades.

Selectarc
BRAZING

SELECTION OF BRAZING ALLOY FOR SIMILAR & DISSIMILAR JOINTS

BASIC METAL	STEEL	ALUMINIUM	COPPER	CAST IRON *(SLOW PREHEATING AND COOLING)*	STAINLESS STEEL	BRASS	GALVANIZED STEEL	NICKEL
NICKEL	BRAZARGENT 5040* BRAZARGENT 5056*	-	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*
GALVANIZED STEEL	CUPROX FC	ZINAL 4 TBW HARASIL NC 12 TBW / TBM	CUPROX FC BRAZARGENT 5034*	CUPROX FC BRAZARGENT 5034*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5034* BRAZARGENT 5040*	CUPROX FC BRAZARGENT 5034*	
BRASS	BRAZARGENT 5034* BRAZARGENT 5040*	ZINAL 4 TBW HARASIL NC 12 TBW / TBM	BRAZARGENT 5034* PHOSBRAZ AG100	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5034* PHOSBRAZ AG100		
STAINLESS STEEL	BRAZARGENT 5040* BRAZARGENT 5056*	ZINAL 4 TBW HARASIL NC 12 TBW / TBM	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*			
CAST IRON *(SLOW PREHEATING AND COOLING)*	CUPROX FC BRAZARGENT 5040*	-	CUPROX FC BRAZARGENT 5040*	CUPROX FC BRAZARGENT 5040*				
COPPER	CUPROX FC	ZINAL 4 TBW HARASIL NC 12 TBW / TBM	PHOSBRAZ M70 *(standard joining)* PHOSBRAZ M60 *(special for pitting)*					
ALUMINIUM	ZINAL 4 TBW HARASIL NC 12 TBW / TBM	ZINAL 4 TBW HARASIL NC 12 TBW / TBM						
STEEL	CUPROX FC							

CHOICE

REF.* : To be used with AG ACTIVE PASTE, flux coated rods or TBW.

CONTENTS

BRAZING ALLOYS

Alloys: *Copper-phosphorus, Copper-phosphorus-silver, Braze-welding alloys, Silver brazing alloys, Flux, Aluminium alloys.*

VIEW OUR FULL RANGE ON WWW.FSH-WELDING.COM

For more information, see our technical data sheets at: *www.fsh-welding.com/en/datasheets.htm*

View our full range on www.fsh-welding.com!

COPPER-PHOSPHORUS ALLOYS

Special range **sparkling free** for great ease in manual applications. This range was invented by André REBOUD, creator of Reboud-Roche plant.

CHOICE

■ **Oven range:**
Consult our technical department.

PHOSBRAZ M60	PHOSBRAZ M70	PHOSBRAZ E80
★ Pasty alloy ★ Wide gaps up to 2 mm	★ Good fluidity ★ Standard gap	★ High fluidity ★ Very small gap

PHOSBRAZ M60

SPECIAL FITTING / COPPER

Alloy recommended for important gap joining, **low fluidity,** self fluxing on coppers (without addition of flux).

- **Standard colour:** copper colour.
- **Brazable grades:** copper alloys.

MAIN APPLICATIONS

★ Brazing of copper-copper connections, mainly in plumbing industry.

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	2.0	500	1
			5
BARE	3.0	500	1
			5

PRODUCT ADVANTAGES:

- Pasty alloy
- Good control of joint filling
- "Flexible"alloy
- Ideal for wide gap up to 2 mm

ISO 17672 CuP 179 | DIN 8513 L-Cu P6

RECOMMENDED HEATING METHOD:

OXY/ACETYLÈNE | INDUCTION

PHOSBRAZ M70

CONTROL FLUIDITY / COPPER

Selectarc BRAZING

Alloy recommended for standard joining (sleeves-fittings). **Good fluidity.** Self-fluxing on copper (without using flux).

- **Standard colour:** copper colour.
- **Brazable grades:** copper alloys.

PRODUCT ADVANTAGES:

- Good fluidity
- Fat brazing
- Universal alloy in plumbing

MAIN APPLICATIONS

★ Brazing of copper-copper connections, mainly in the plumbing field.

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	2.0	500	1
			5
BARE	3.0	500	1
			5

ISO 17672 CuP 180 | DIN 8513 L-Cu P7 | AWS A5.8 B Cu-P 2

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION

PHOSBRAZ E80

EXCELLENT FLUIDITY / COPPER

Selectarc BRAZING

Alloy recommended for small gap with large overlap. **Product with high fluidity.** Self-fluxing on copper (without addition of flux).

- **Standard colour:** copper colour.
- **Brazable grades:** copper alloys.

PRODUCT ADVANTAGES:

- High capillarity on small gap
- Low brazing temperature
- Large overlap
- Can be used with an aero-propane flame*

MAIN APPLICATIONS

★ Brazing of copper to copper and copper to brass connections, mainly in plumbing.

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	2.0	500	1
			5
BARE	3.0	500	1
			5

ISO 17672 CuP 182 | DIN 8513 L-Cu P8

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION | AERO-PROPANE

*Subject to testing, under customer responsibility.

COPPER - PHOSPHORUS - SILVER ALLOYS

CHOICE

PHOSBRAZ AG20+
- ★ Universal
- ★ Economical

PHOSBRAZ AG50
- ★ Easy to use
- ★ Good resistance to mechanical vibrations

PHOSBRAZ AG60
- ★ Copper pipes

PHOSBRAZ AG100
- ★ Copper-brass assembly
- ★ Excellent technical and economical compromise

PHOSBRAZ AG150
- ★ Electrical connections

PHOSBRAZ AG20+

UNIVERSAL / COPPER 2 % Ag

Selectarc BRAZING

This alloy is recommended for standard joining with a **good fluidity** and is self-fluxing on copper. This alloy has **2 % Ag in addition to phosphorus for a better capillarity.**

- **Standard colour:** copper colour.
- **Brazable grades:** copper alloys.

MAIN APPLICATIONS

★ Copper-copper joining in sleeve coupling and fittings, heat exchangers (hot/cold) and ventilation systems.

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	2.0	500	1
			5
BARE	3.0	500	1
			5

PRODUCT ADVANTAGES:

- Multi purpose alloy
- Good fluidity
- The most economical of the copper-phosphorus-silver range
- Easy to use

ISO 17672 CuP 279 | DIN 8513 L-Ag 2 P

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION

PHOSBRAZ AG50

AC / VIBRATIONS / COPPER 5% Ag

Selectarc BRAZING

Alloy with **5% Ag** in addition phosphorus for a better capillarity is recommended for all assemblies and particularly for air conditioning. Its main features are: **good ductility and very good fluidity**.This product is self-fluxing on copper.

- **Standard colour:** copper colour.
- **Brazable grades:** copper alloys.

MAIN APPLICATIONS

★ Copper to copper joining in sleeve coupling, fittings, heat exchangers (hot/cold), ventilation systems and compressors.

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	2.0	500	1
			5
BARE	3.0	500	1
			5

PRODUCT ADVANTAGES:

- Resistance to mechanical vibrations and chocs, better than a CuP
- Very good fluidity
- Brazing temperature is lower than AG20+

ISO 17672 CuP 281 | AWS A5.8 BCuP-3

RECOMMENDED HEATING METHOD:

OXY/ACETYLÈNE | INDUCTION

PHOSBRAZ AG60

PIPING / COPPER 6% Ag

Selectarc BRAZING

Copper-phosphorus alloy with **6% Ag** for brazing of copper. It is recommended for gas systems and piping systems. It can be used with propane gas*.

- **Standard colour:** copper colour.
- **Brazable grades:** copper alloys.

MAIN APPLICATIONS

★ Piping and combustible gas installations.

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	2.0	500	1
			5
BARE	3.0	500	1
			5

PRODUCT ADVANTAGES:

- High fluidity
- Low melting temperature
- Excellent wetting property and capillarity

ISO 17672 CuP 283a

RECOMMENDED HEATING METHOD:

OXY/ACETYLÈNE | INDUCTION | AERO-PROPANE

*Subject to testing, under customer responsibility.

PHOSBRAZ AG100

FLUX COATED

COPPER / BRASS ASSEMBLIES 10 % Ag

Selectarc BRAZING

Alloy with **10 % Ag** recommended for copper-copper joining, copper alloys (brass…). Very good fluidity. An alloy of exceptional performance: **"Global economic solution" for copper to brass assemblies.**

- **Standard colour:** coating colour white.
- **Brazable grades:** copper and copper alloys (e.g : brass).

MAIN APPLICATIONS

★ Brazing of brass connections on copper piping.

Type	Ø (mm)	Length (mm)	Kg/Pkt
COATED	2.0	500	1
			5

PRODUCT ADVANTAGES:

- "2 in 1" (coated rod)
- Alloy ready to use
- Excellent compromise between fluidity & ductibility
- Excellent wetting property
- Can be used with propane gas*

EN ISO 3677
B Cu 84 Ag P 650-750

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | AERO-PROPANE

*Subject to testing, under customer responsibility.

PHOSBRAZ AG150

ELECTRICAL CONNECTIONS / COPPER 15 % Ag

Selectarc BRAZING

Alloy recommended for assembling with white gap. **Good fluidity,** self-fluxing on copper.

- **Standard colour:** copper colour.
- **Brazable grades:** coppers.

MAIN APPLICATIONS

★ Copper to copper assemblies, electric engines production, electrical connections, air conditioning.

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	2.0	500	1
			5
BARE	3.0	500	1
			5

PRODUCT ADVANTAGES:

- Excellent electrical conductivity
- Ductile alloy
- Very good mechanical resistance
- Allow the filling of white gap

ISO 17672	DIN 8513	AWS A5.8
CuP 284	L-Ag 15 P	BCuP-5

RECOMMENDED HEATING METHOD:

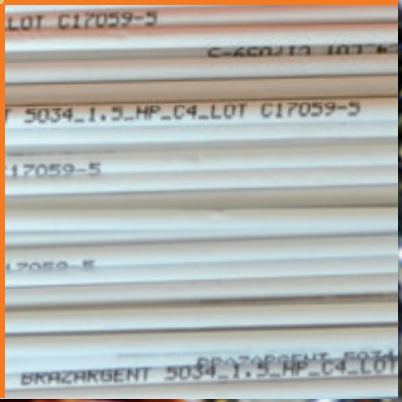
OXY/ACETYLENE | INDUCTION

BRAZE-WELDING

Braze-welding is a brazing process in which the joint is done by butt joining with a similar method to fusion welding. With this technique, there is no capillary action.

Usually, the braze-welding method is better than the autogenous welding for steel assembly of unknown grades or poor welding grades.

This is a particularly economical joining technique, which is faster and better than autogenous welding method for some applications.



BRAZE-WELDING ALLOYS

CUPROX
★ Universal alloy

NICROX 49 C1
★ Better mechanical strength

CHOICE

CUPROX

FLUX COATED ROD

JOINING AND REPAIR: STEEL, COPPER, CAST IRON

Selectarc BRAZING

Brass for braze-welding, recommended for steel assembly and copper alloys. Alloy ready to use.

■ **Brazable grades: carbon steels, moulded steels, copper, bronze, nickel, cast-iron (with caution).**

MAIN APPLICATIONS

★ Metalwork, steel piping, decorative elements for furniture, pipework, decorative utensils.

Type	Ø (mm)	Length (mm)	Kg/Pkt
SIENA CALCINED COATING	2.0	500	1
			5

Customized sizes are available.

PRODUCT ADVANTAGES:

- High quality alloy
- Universal alloy for braze-welding
- High mechanical resistance
- Good elongation

ISO 17672	DIN 8513	AWS A5.8
~ Cu 471	L CuZn40	~ RCu-Zn C

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE

NICROX 49 C1

FLUX COATED ROD

HIGH RESISTANCE BRAZE-WELDING

Selectarc BRAZING

Brass alloy with nickel (Cu-Zn-Ni). NICROX 49 C1 is 10 % nickel alloy and has excellent mechanical resistance (higher than CUPROX). Alloy ready to use. It can be used on coated pipes.

■ **Brazable grades: carbon steels, moulded steels, copper, carbide, cast-iron (with caution).**

MAIN APPLICATIONS

★ Metalwork, bicycle frames, metal furnitures, carbide inserts.

Type	Ø (mm)	Length (mm)	Kg/Pkt
COATED	2.0	500	1
			5

Customized sizes are available.

PRODUCT ADVANTAGES:

- Very good mechanical resistance
- Uniformed deposits
- Nice bead profile
- "2 in 1"

ISO 17672	DIN 8513	AWS A5.8
Cu 773	L CuNi10Zn42	Rcu-Zn D

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE

SILVER ALLOYS

BRAZING FOR ALL METALS EXCEPT ALUMINIUM

CHOICE

BRAZARGENT 5034
- ★ Better technico-economical alloy
- ★ Good fluidity

BRAZARGENT 5040
- ★ Universal brazing
- ★ Good fluidity

BRAZARGENT 5045
- ★ Good fluidity
- ★ Good mechanical properties

BRAZARGENT 5055
- ★ Good wettability
- ★ Easy for profile building

BRAZARGENT 5056
- ★ High mechanical brazing characteristics
- ★ Excellent fluidity

BRAZARGENT 5034

BEST TECHNICAL-ECONOMICAL RATIO

Selectarc BRAZING

Quaternary alloy with **34 % Ag**. It is recommended for all similar and dissimilar joining. Very good brazing properties. High efficient and economical alloy. Can be used as bare rod with AG ACTIVE PASTE, in flux coated rod, or TBW.

■ **Brazable grades: ferrous alloys, copper alloys, nickel alloys, stainless steels and tool steels, except aluminium alloys.**

MAIN APPLICATIONS

★ Household electrical appliances, sanitary and food industry, medical fluids transport, tools, plumbing, delicate works...

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	1.5	500	0.25 - 1
BARE	2.0	500	0.25 - 1
COATED	1.5	500	0.25 - 1
COATED	2.0	500	0.25 - 1
TBW	1.5	500	0.25 - 1
TBW	2.0	500	0.1 - 0.25 - 1

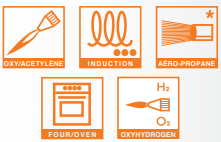
Customized sizes are available.

PRODUCT ADVANTAGES:

- Good fluidity
- Good wetting property
- Excellent mechanical properties
- Recommended for small gap

ISO 17672	DIN 8513
Ag 134Si	L-Ag 34 Sn

RECOMMENDED HEATING METHOD:



**Subject to testing, under customer responsibility.*

BRAZARGENT 5040

UNIVERSAL Ag BRAZING

Selectarc BRAZING

Multi-purpose quaternary alloy with **40% Ag**. It is recommended for all similar and dissimilar joining. Very good brazing properties and tensile strength. Alloy to be used as bare rods with AG ACTIVE PASTE, in flux coated rod or TBW.

■ **Brazable grades: ferrous alloys, copper alloys, nickel alloys, stainless steels and tool steels, except aluminium alloys.**

MAIN APPLICATIONS

★ Food industry, medical fluids transport, immersion heaters, cooling systems, compressors, delicate works, and art wares…

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	1.5	500	0.25 - 1
BARE	2.0	500	0.25 - 1
COATED	1.5	500	0.25 - 1
COATED	2.0	500	0.25 - 1
TBW	1.6	500	0.25 - 1
TBW	2.0	500	0.1 - 0.25 - 1

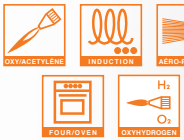
Customized sizes are available.

PRODUCT ADVANTAGES:

- Excellent fluidity
- Good corrosion resistance
- Easy to use

ISO 17672	DIN 8513	AWS A5.8
Ag 140Si	L-Ag 40 Sn	BAg-28

RECOMMENDED HEATING METHOD:



*Subject to testing, under customer responsibility.

BRAZARGENT 5045

GOOD CAPILARITY BRAZING ALLOY

Selectarc BRAZING

Quaternary alloy containing **45 % silver.** BRAZARGENT 5045 is the standard brazing alloy. Suitable for use for delicate jobs. This alloy offers good performance in terms of operating brazeability (melting point/fluidity) and good mechanical properties. To be used in conjunction with AG ACTIVE PASTE, in the form of flux coated rod or TBW.

■ **Brazable grades: ferrous alloys, copper alloys, nickel alloys, stainless steels and tool steels, except aluminium alloys.**

MAIN APPLICATIONS

★ Food industry, medical fluids transport, immersion heaters, cooling systems, compressors, delicate works, and art wares…

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	1.5	500	0.25 - 1
BARE	2.0	500	0.25 - 1
COATED	1.5	500	0.25 - 1
COATED	2.0	500	0.25 - 1
TBW	1.6	500	0.25 - 1
TBW	2.0	500	0.25 - 1

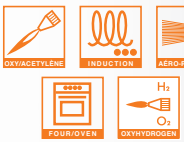
Customized sizes are available.

PRODUCT ADVANTAGES:

- Operating characteristic recomanded for small gap
- Better fluidity than Brazargent 5040

ISO 17672	DIN 8513	AWS A5.8
Ag 145Si	L-Ag 45 Sn	~BAg-36

RECOMMENDED HEATING METHOD:



*Subject to testing, under customer responsibility.

BRAZARGENT 5055

HIGH AG ALLOYS
GOOD WETTABILITY

Selectarc BRAZING

Cadmium free alloy which main elements are: copper, zinc, silver **(55%)** and tin. Silver and tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in fitting joints.

■ **Brazable grades: ferrous alloys, copper alloys, nickel alloys, stainless steels and tool steels, except aluminium alloys.**

PRODUCT ADVANTAGES:

- Good performance
- Profile building easy
- Corrosion resistance

MAIN APPLICATIONS

★ Can be used for brazing any steels, copper and copper based alloys, stainless steels, as well for nickel and nickel based alloys.

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	1.5	500	0.25 - 1
BARE	2.0	500	0.25 - 1
COATED	1.5	500	0.25 - 1
COATED	2.0	500	0.25 - 1

Customized sizes are available.

ISO 17672 Ag 155Si

DIN 8513 L-Ag 55 Sn

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE · INDUCTION · AERO-PROPANE · FOUR/OVEN · OXYHYDROGEN (H_2 / O_2)

**Subject to testing, under customer responsibility.*

BRAZARGENT 5056

VERY HIGH MECHANICAL PROPERTIES

Selectarc BRAZING

Quaternary alloy with **56% Ag**, for all high safety assemblies. This alloy has the lowest melting point of our BRAZARGENT range. Excellent capillarity and very good brazing joints appearance. Alloy to be used as bare rod with AG ACTIVE PASTE, in flux coated rod, or TBW.

■ **Brazable grades: ferrous alloys, copper alloys, nickel alloys, stainless steels and tool steels, except aluminium alloys.**

MAIN APPLICATIONS

★ Food industry, medical tools, cooling systems, compressors, specific assemblies, jewellery…

Type	Ø (mm)	Length (mm)	Kg/Pkt
BARE	1.5	500	0.25 - 1
BARE	2.0	500	0.25 - 1
COATED	1.5	500	0.25 - 1
COATED	2.0	500	0.25 - 1
TBW	1.5	500	0.25 - 1
TBW	2.0	500	0.1 - 0.25 - 1

Customized sizes are available.

PRODUCT ADVANTAGES:

- Excellent fluidity
- High capillarity
- Nice appearance
- Very good elongation

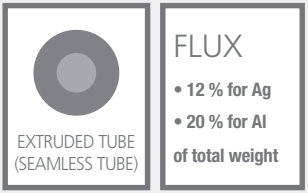
ISO 17672	AWS A5.8	DIN 8513
Ag 156Si	BAg-7	L-Ag 56 Sn

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE · INDUCTION · AERO-PROPANE* · FOUR/OVEN · OXYHYDROGEN (H_2 O_2)

*Subject to testing, under customer responsibility.

TUBULAR BRAZING WIRE



TUBULAR BRAZING WIRE (TBW)

TBW is a brazing flux cored wire used for manual as well as automatic brazing. The flux is filled in the extruded seamless tube ensuring a constant alloy to flux ratio. This filled tube is drawn to lower diameter in steps.

ART COMING OF FLUX FROM THE TUBE

FLUX START MELTING

BRAZING COMPLETED WITHOUT OVER-SPILLAGE

MEAN FEATURES

Easy to use: 2 in 1 product, no additional fluxing

TBW is a cost economic solution compared with conventional brazing products:

- less alloy consumption: optimum usage of alloy and limit over-flow
- higher productivity: consistent quality and mechanized brazing
- less rejection: better visibility during operation
- less post-braze cleaning: less residues due to optimum flux ratio
- less inventory: no need of paste appliance and more storage space
- less consumable wastage: no coating fragility

User-friendly:

- less fatigue: less fumes, no fluxing
- better operator safety: no splashing

Health & safety:

- no physical contact with the flux/coating
- environmental friendly: conform to REACH/ECHA and RoHS
- higher shelf life even in tropical climates

Available in different forms (rods, spools, rings, preforms...)

PRODUCT RANGE

Type	% Ag	Alloy	EN ISO 17672	AWS A5.8	Melting range (°C)
BRAZARGENT 5034 TBW	34	Cu-Ag-Zn-Sn	Ag 134Si	-	630-730
BRAZARGENT 5040 TBW	40	Cu-Ag-Zn-Sn	Ag 140Si	BAg-28	650-710
BRAZARGENT 5045 TBW	45	Cu-Ag-Zn-Sn	Ag 145Si	~BAg-36	640-680
BRAZARGENT 5055 TBW	55	Cu-Ag-Zn-Sn	Ag 155Si	-	630-660
BRAZARGENT 5056 TBW	56	Cu-Ag-Zn-Sn	Ag 156Si	BAg-7	620-655
HARASIL NC 12 TBW	-	Al-Si (88:12)	Al112		575-585
ZINAL 4 TBW	-	Zn-Al (98:2)	**DIN 1707-100 :** S-Zn 98 Al 2		382-420

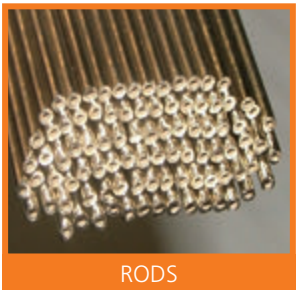
DIMENSIONS AND DIFFERENT FORMS AVAILABLE

Rod = diam x length (mm)	Wire diameter (mm)	Internal ring diameter (ID, mm)	Weight per spool (D100, D200, D300…)	Coils (dimensions, weight)
1.00 to 5.00 x 500 / 1000	0.80 to 3.00	2.00 to 20.00 or more	0.500 to 10 Kg/spool	on request

Note: Customized alloys, wire sizes and pre-forms can be manufactured on request.


SPOOL


RINGS


RODS


PACKING

FLUX

AG ACTIVE PASTE

EXCELLENT FLUX

Selectarc BRAZING

NEW PRODUCT

ECO

Ready to use. A stream of strong brazing for copper, stainless steel and nickel alloys. A white paste composed of a mixture of complex fluoroborates ensuring a very good protection of the brazing component at high temperatures. Free of boric acid and soluble borates.

Type	Kg/Pkt
PASTE	0.5 - 1

PRODUCT ADVANTAGES:

- Better flux homogenity
- Good sticking property
- Less sedimentation
- Better cleaning

FLUX EN 1045
FH10

RECOMMENDED HEATING METHOD:

OXY/ACETYLÈNE · INDUCTION · AÉRO-PROPANE · FOUR/OVEN · H_2 O_2 OXYHYDROGEN

*Subject to testing, under customer responsibility.

Selectarc *For more information, see our technical data sheets at:* www.fsh-welding.com/en/datasheets.htm

ZINC ALLOY

ZINAL 4 TBW

DISSIMILAR JOINING

Selectarc BRAZING

Seamles tubular wire with non-corrosive flux at core and a melting point around 440°C. This alloy is intended to be used to braze Mg-free aluminium with other metals.

■ **Brazable grades: aluminium to copper, stainless steels, steels, brass.**

MAIN APPLICATIONS

★ Heat exchangers, household electrical appliances, steel-aluminium electric connection, and galvanized-steel-aluminium.

Type	Ø (mm)	Kg/Pkt
TBW	2.0	1

Customized sizes are available.

PRODUCT ADVANTAGES:

- Tubular technology
- Aluminium-copper joining
- Low working temperature

DIN 8513
L-ZnAl2

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | AÉRO-PROPANE | OXYHYDROGEN

*Subject to testing, under customer responsibility.

ALUMINIUM ALLOY

HARASIL NC 12 TBW

Al - Al/Cu ASSEMBLIES

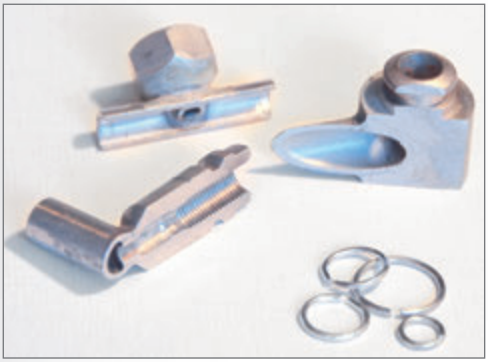
Selectarc BRAZING

Alloy to be used to braze Mg-free aluminium. Seamless tubular wire with non-corrosive flux at core. Melting point: 575-585°C.

■ **Brazable grades:** mainly aluminium and aluminium-stainless steels and copper.

Type	Ø (mm)	Kg/Pkt
TBW	2.0	1

Customized sizes are available.



PRODUCT ADVANTAGES:

- Good fluidity
- Good capillarity
- Nice appearance

ISO 17672	AWS A5.8	DIN 8513
Al 112	BAlSi-4	L-AlSi 12

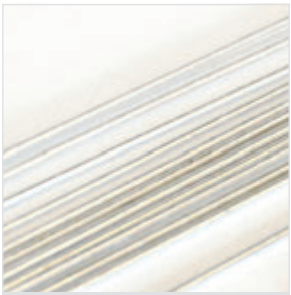
RECOMMENDED HEATING METHOD:

OXY/ACETYLENE · INDUCTION · AERO-PROPANE · FOUR/OVEN · H_2 O_2 OXYHYDROGEN

**Subject to testing, under customer responsibility.*

FORMS

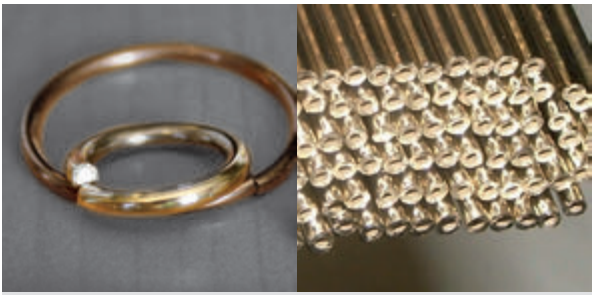
■ **Products available as:**



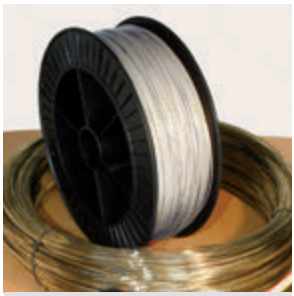
BARE RODS

FLUX-COATED RODS

PREFORMS



BARE RODS, TUBULAR BRAZING RODS, WIRE & PREFORMS



SPOOLS OR COILS

PACKING

■ **Standard according to range.**

Consult us for your specific requests!

Selectarc
by FSH WELDING GROUP

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