



Sil Sol 56%™ - 56% Silver Solder Flux Covered

Applications & Features

Use for joining and repairing stainless steel components, especially when color match is critical. Ideal for tubing, instruments, switches, ornamental trim, hospital equipment and laboratory equipment. Universal alloy for general maintenance and repair, now with reduced charring.

The cadmium free, high silver content makes Sil Sol 56% the ultimate choice for joining ferrous and non-ferrous metals. Ideal for food and pharmaceutical as well as general industrial use.

Is effective with any of these heat sources :

- Oxy-acetylene torch
- Natural gas torch

Properties

Composition		Range
Ag (Silver) :		30-60%
Cu (Copper):		10-40%
(Zinc (as oxide)):		10-35%
Sn (Tin):		1-7%
H ₃ BO ₃ (Boric Acid):		7-13%
HF ₂ K (Potassium Bifluoride):		7-13%
K ₂ B ₄ O ₇ (Potassium Tetraborate):		7-13%
KF (Potassium Fluoride):		7-13%
KBF ₄ (Potassium Fluoborate):		0.5-1.5%
Technical Data		
Tensile Strength:		76,000 psi (524 N/mm ²)
Working Temperature		Approx. 1200°F (660°C)
Elongation %		Approx. 22%
Corrosion Resistance		Good
Color Match		Good on Stainless Steel
Electrical Conductivity		Good

Product Variants

Sil Sol 56%™ - Is sold in 10 and 3 rod packs.

Procedure

Prepare surfaces to be joined by mechanical or chemical cleaning, grind a "V" into any cracks needing a strong fill and bond. Fixture parts to maintain alignment. Joint clearance should not exceed .003". Heat parts uniformly with a slightly carburizing flame. Place Sil Sol 56% flux directly on the heated joint. When the flux becomes clear and fluid, melt a small amount of alloy onto the joint and continue heating to uniformly spread the alloy through the entire joint area. DO NOT OVERHEAT THE BASE METAL. Allow the part to cool slowly and completely, then remove flux residue with warm water.