

# **SolderWeld, Inc. SIL SOL 56% Premium Silver Solder**

Sil Sol 56% Silver solder is the top Silver solder in the market and is perfect for engine block repair, cast iron repair and anything that will get real hot after the repair is made such as exhaust manifolds. The perfect solution for all serious repairs in many industries.

Sil Sol is flux covered and allows you to bathe the joint in flux while heating the joint to perfect application temperature. This will allow the solder to flow out and fill the voids nicely on your repairs.

Close tolerances must be held on holes and fittings and the tighter the better is always best.

Once you have a properly cleaned and prepared joint and repair area, begin heating around the area to be soldered. Bring the metal to a dull red and melt the flux off of the rod onto the joint and begin heating the area away from the actual joint. This will help keep the heat in the joint when you do melt the solder and keep the solder from making a "Cold Joint". The flux will become a clear liquid and this will indicate its time to add a small amount of the silver solder rod. Once you have sufficiently warmed the surrounding area, apply more flux and heat the area you wish to solder.

Once the solder melts continue to heat and allow the temp to reside slowly while keeping the area well covered in flux. When the joint cools completely, clean any remaining flux from the area with warm water and/or brush lightly with a stainless steel bristle brush reserved for silver soldering only and your joint will be smooth and shiny in addition to being air and water tight.

Most issues arise from attempting to heat the solder directly and not allowing the joint to dictate the flow of the joint. SolderWelds premium silver solder, flows like butter and we suggest using an Oxy/Acetylene torch however a MAPP gas cylinder torch in some cases is adequate as well.

The trick we believe is getting the heat uniformly and indirectly on the joint as compared to directly heating the solder and the joint with insufficient flux to exclude extraneous air and possible contaminants from the disturbing of the flame.