

Brazing Alloys, Solders & Fluxes

MARS SERIES 793

High Silver Brazing Alloys - 1/16" Dia. Coils

In refrigeration applications, much of the brazing involves joining copper tubing. However, there are numerous applications where other materials need to be joined (steel, brass, stainless, etc.). These high silver brazing alloys facilitate the joining of these metals. The one alloy in particular which is highly recommended for virtually all above mentioned base metals is Braze[®] 505. It's advantages over 56% and 45% include:

- It contains 2% Nickel which enhances wetting and strength and facilitates the joining of steels, stainless steel, carbide, etc.
- It doesn't contain tin. This prevents the formation of brittle intermetallics which can cause joint failures when stresses accumulate.
- The flow characteristics can be easily manipulated by either fast or slow heating techniques this allows bridging of gaps.
- It's available in flux-coated rod for added convenience and ease-ofuse: No separate fluxing operation.

Braze[®] 450 is a general purpose filler metal for joining ferrous, non-ferrous and dissimilar metals with large joint clearances. Cadmium-free.

Braze[®] 505 is the best general purpose filler metal available. It is the only alloy recommended for stainless steel (as it retards/eliminates interface corrosion) and carbide applications. Nickel content provides superior adhesion ("wetting") to base metal surfaces. Available, and especially convenient, as flux coated rod. Cadmium-free.

Braze[®] 560 is the lowest temperature, Cadmium-free filler metal available. This is a good general purpose alloy for close joint tolerances.





MARS			COMPOSITION %					TEMPERATURE		MARS	CASE
NO.	AWS SPE		Ag	Cu	Zn	Sn	Other	MELT	FLOW	PACK	QTY.
78305	Braze [®] 450 1oz	BAg-5	45	30	25			1225° F	1370° F	1	24
78306	Braze [®] 450 3oz									1	24
78307	Braze® 450 5oz									1	24
78308	Braze [®] 505 1oz	BAg-24	50	20	28		2 Ni	1220° F	1305° F	1	24
78309	Braze [®] 505 3oz									1	24
78310	Braze® 505 5oz									1	24
78314	Braze [®] 505 F/C, Flux coated rod, 18" stick x 1/4 lb tube	BAg-24	50	20	28		2 Ni	1220° F	1305° F	1	15

Brazing & Solder Fluxes

Where fluxing is required as part of the brazing operation, Handy Flux is recommended. Handy Flux is an all-purpose flux for use in brazing both ferrous and non-ferrous metals and alloys. Handy Flux conforms to: AWS Brazing Flux Type #3A, Federal Spec. O-F-499d (216185) Type B, Society of Automotive Engineers AMS-3410G. For soldering applications we offer two different flux products depending on the materials to be joined. They include Cleann-Brite Flux for general purpose applications and TEC Liquid Flux where more aggressive fluxing is required for the more difficult-to-solder materials (e.g. steel, stainless steel, etc.).

MARS NO.	DESCRIPTION	MARS PACK	CASE QTY.
78315	Handy Flux - 7oz. jar w/brush cap	1	24
78319	TEC Liquid Flux - 4oz. squeeze bottle	1	48
78320	Clean-n-Brite Flux -4oz. paste w/brush	1	24



