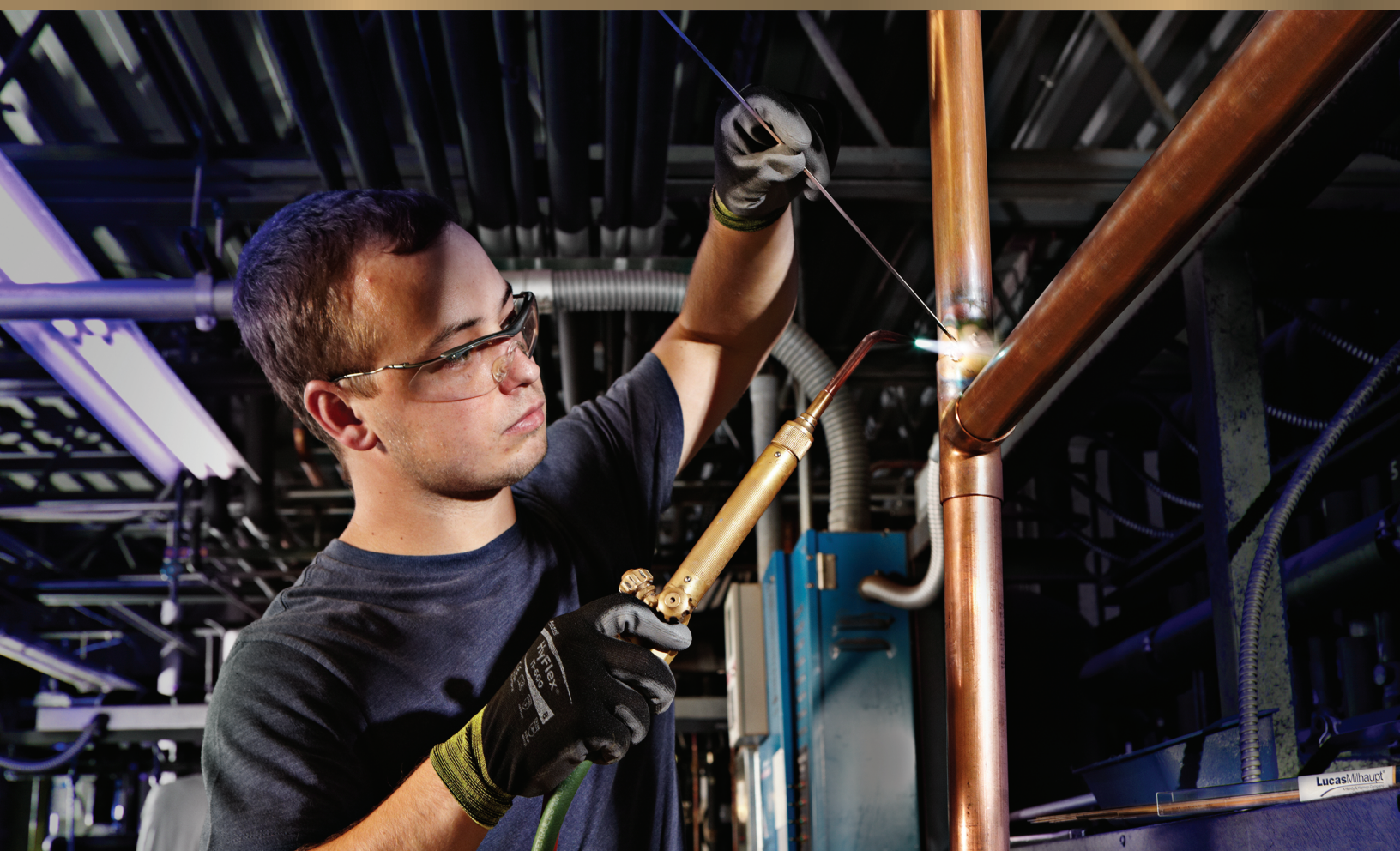


YOUR COMPLETE SOURCE FOR
BRAZING & SOLDERING
ALLOYS & FLUXES



LucasMilhaupt®
A STEEL PARTNERS COMPANY

WE HAVE EXPANDED OUR COMMITMENT TO THE METAL JOINING INDUSTRY

For more than seventy-five years, you've relied on Lucas-Milhaupt to provide superior brazing products. Our extensive product knowledge, ready inventory of brazing and soldering materials, and technical expertise has enabled us to offer our customers a level of support unmatched in the industry.

Since we became part of Handy & Harman in 1967, we've continued to grow our leadership position. Founded more than a century ago in 1867, Handy & Harman had long been recognized as a leading company in precious metal fabrication, processing and refining. Together, we have continued to raise the bar of quality and manufacturing excellence.

We've now taken another leap ahead - expanding our commitment to the metal joining industry - by acquiring the brands, manufacturing capabilities, and expertise of Wolverine Joining Technologies. Historically, Wolverine's offerings have complemented those in the Lucas-Milhaupt line, but have typically been sold through different outlets. This JOINING of two leaders offers YOU the advantages of both:

- Expanded network of distribution points for even better availability
- Expanded sales support network
- Broader range of product line to better serve your needs
- Commitment to USA manufacturing
- Technical support – a recognized Lucas-Milhaupt strength!

Joining the legacies of these two industry leaders positions Lucas-Milhaupt to be even stronger, and to support our customers well into the future! The new, stronger brazing leader, with the backing of a global metals power.

The new Lucas-Milhaupt – committed to your metal joining needs today...and into the future.



SIL-FOS® Family of Brazing Alloys


For Joining Copper and Copper-based Alloys.


This group of alloys allows the joining of copper to copper without a flux and copper based alloys (brass and bronze) with a flux. The family of products includes the original Sil-Fos 15. Developed and patented over 75 years ago, Sil-Fos is the workhorse filler metal used in the refrigeration and air conditioning industry.


Think of the brazing alloy as the glue that holds the refrigeration system together. The thermal cycling (and subsequent expansion and contraction), vibration stresses and higher pressures of the new refrigerants strongly suggest that the ductility of the braze alloy is extremely important—not just for an initial leak tight joint, but to be hermetic for many years down the road.


SIL-FOS® 15	Best alloy for general copper-copper brazing in the Sil-Fos family. For copper-to-copper joints the phosphorus in the Sil-Fos product serves as the fluxing agent and no separate flux is necessary. For brass applications however, flux is recommended. For use where close fit-ups cannot be maintained Sil-Fos 15 works well to "bridge" gaps. Highest joint ductility of the entire Sil-Fos family to best withstand the stresses inherent in refrigeration applications. Slow Flow.			AWS Spec	Compositions %			Melt	Flow
				BCuP-5	Ag 15	Cu 80	P 5	1190°F 643°C	1475°F 802°C
Product Name	Item #	Description	Case Qty.						
Sil-Fos® 15	95150	.125" x .050" x 20" x 28 Rods	25 lb.						
Sil-Fos® 15*	95161	.125" x .050" x 20"	25 lb.						
Sil-Fos® 15	1202092	.125" sq. x 20" x 11 Rods in Plastic Tube	25/Box						
Sil-Fos® 15	95177	.125" x .050" x 20" x 7 Rods in Plastic Tube	20/Box						
Sil-Fos® 15	1202082	.125" sq. X 36"	25 lb.						
Sil-Fos® 15*	95158	.094" Dia. X 36"	25 lb.						
Sil-Fos® 15 Coil	32181	.050" x .125" x 5' length	6/Box						
Sil-Fos® 15 Coil	32183	.050" x .125" x 22' length	5/Box						



HANDY-FLO® 6				AWS Spec	Compositions %			Melt	Flow
Recommended for use where a close fit-up cannot be maintained. Has the ability to fill gaps and form fillets without affecting joint strength. Slow Flow. (formerly Sil-Fos® 6M)				None	Ag 6	Cu 88	P 6	1190°F 645°C	1460°F 795°C
Product Name	Item #	Description	Case Qty.						
Handy-Flo® 6	95120	.125" x .050" x 20" – 28 Rods	25 lb.						
Handy-Flo® 6	95131	.125" x .050" x 20"	25 lb.						

SIL-FOS® 5				AWS Spec	Compositions %			Melt	Flow
Designed primarily for those applications where close fit-ups cannot be maintained. It has the ability to fill gaps and form fillets without adversely affecting joint strength. Slow Flow.				BCuP-3	Ag 5	Cu 89	P 6	1190°F 643°C	1495°F 813°C
Product Name	Item #	Description	Case Qty.						
Sil-Fos® 5	95060	.125" x .050" x 20" – 28 Rods	25 lb.						
Sil-Fos® 5	95071	.125" x .050" x 20"	25 lb.						
Sil-Fos® 5 Coil	32299	.050" x .125" x 5' length	6/Box						
Sil-Fos® 5 Coil	32302	.050" x .125" x 22' length	5/Box						

SIL-FOS® 2				AWS Spec	Compositions %			Melt	Flow
A filler metal with comparable characteristics to Fos-Flo 7. Medium Flow.				BCuP-6	Ag 2	Cu 91	P 7	1190°F 643°C	1450°F 788°C
Product Name	Item #	Description	Case Qty.						
Sil-Fos® 2	95030	.125" x .050" x 20" – 28 Rods	25 lb.						

FOS-FLO®				AWS Spec	Compositions %			Melt	Flow
An economical, very fluid medium temperature filler metal for use with copper, brass and bronze. Withstands moderate vibration. Fast Flow.				BCuP-2	Ag 0	Cu 92.75	P 7.25	1310°F 709°C	1460°F 793°C
Product Name	Item #	Description	Case Qty.						
Fos-Flo®	95000	.125" x .050" x 20" – 28 Rods	25 lb.						
Fos-Flo®*	95011	.125" x .050" x 20"	25 lb.						



**Brazing Copper to Brass
with SIL-FOS®**



**Brazing Copper to Copper
with SIL-FOS®**

*Lead Times and Minimums may Apply


.125" x .050" x 20"
(3.2 mm x 1.27 mm x 510 mm)


High Silver Brazing Alloys

For joining ferrous (iron-based) and non-ferrous materials.

Brazing is so universally used because it is economical, easy to do and produces strong leak-tight joints. It is also a flexible process that allows you to join both similar and dissimilar metals. 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 steel, carbide, etc.) These high silver brazing alloys facilitate the joining of these metals.

Lucas-Milhaupt offers these high silver alloys in a variety of package sizes and wire diameters depending upon your needs and application. For added convenience, several of these alloys are available as flux coated rods or flux cored rods. This eliminates the separate fluxing operation previously required when using this family of alloys.

SILVALOY® 560				Lowest temperature, Cadmium-free filler metal, very fluid alloy flow Formerly Braze™ 560		AWS Spec	Compositions %				Melt	Flow
						BAg-7	Ag 56	Cu 22	Zn 17	Sn 5	1145°F 618°C	1205°F 652°C
Product Name	Item #	Description	Case Qty.									
Silvaloy® 560	98060	1/16" (1.6 mm) Dia. x 1 Troy Oz. Clam Shell	6/Box									
Silvaloy® 560	98062	1/16" (1.6 mm) Dia. x 5 Troy Oz. Clam Shell	6/Box									
Silvaloy® 560*	98064	3/32" (2.4 mm) Dia. x 50 Troy Oz. Knock-out Box	1/Box									
Silvaloy® 560	98065	1/16" (1.6 mm) Dia. x 50 Troy Oz. Knock-out Box	1/Box									
Silvaloy® 560*	98067	1/32" (0.8 mm) Dia. x 50 Troy Oz. Knock-out Box	1/Box									

SILVALOY® 505				Best general purpose filler metal available. Recommended for stainless steel as it retards interface corrosion. Nickel content provides superior adhesion to base metal surfaces. Formerly Braze™ 505		AWS Spec	Compositions %				Melt	Flow
						BAg-24	Ag 50	Cu 20	Zn 28	Ni 2	1220°F 660°C	1305°F 705°C
Product Name	Item #	Description	Case Qty.									
Silvaloy® 505	98070	1/16" (1.6 mm) Dia. x 1 Troy Oz. Clam Shell	6/Box									
Silvaloy® 505	98072	1/16" (1.6 mm) Dia. x 5 Troy Oz. Clam Shell	6/Box									
Silvaloy® 505*	98050	3/32" (2.4 mm) Dia. x 50 Troy Oz. Knock-out Box	1/Box									
Silvaloy® 505	98051	1/16" (1.6 mm) Dia. x 50 Troy Oz. Knock-out Box	1/Box									
Silvaloy® 505*	98053	1/32" (0.8 mm) Dia. x 50 Troy Oz. Knock-out Box	1/Box									

Additional diameters available upon request
Minimums may apply



**Joining Brass to Copper
with SILVALOY®**



SILVALOY® 452		Low temperature, general-purpose alloy with better flow properties than Silvaloy® 450. Formerly Braze™ 452		AWS Spec	Compositions %			Melt	Flow	
				BAg-36	Ag 45	Cu 27	Zn 25	Sn 3	1195°F 646°C	1251°F 677°C
Product Name	Item #	Description	Case Qty.							
Silvaloy® 452	98010	1/16" (1.6 mm) Dia. x 1 Troy Oz. Clam Shell	6/Box							



SILVALOY® 450		General purpose filler metal for joining ferrous, non-ferrous and dissimilar metals with large joint clearances. Formerly Braze™ 450		AWS Spec	Compositions %			Melt	Flow	
				BAg-5	Ag 45	Cu 30	Zn 25	1225°F 663°C	1370°F 743°C	
Product Name	Item #	Description	Case Qty.							
Silvaloy® 450	98000	1/16" (1.6 mm) Dia. x 1 Troy Oz. Clam Shell	6/Box							
Silvaloy® 450	98002	1/16" (1.6 mm) Dia. x 5 Troy Oz. Clam Shell	6/Box							
Silvaloy® 450*	98004	3/32" (2.4 mm) Dia x 50 Troy Oz. Knock-out Box	1/Box							
Silvaloy® 450	98005	1/16" (1.6 mm) Dia x 50 Troy Oz. Knock-out Box	1/Box							
Silvaloy® 450*	98007	1/32" (0.8 mm) Dia x 50 Troy Oz. Knock-out Box	1/Box							



SILVALOY® 401		A more economical filler metal with a fairly narrow melt range, this alloy has application for both steel and copper-based materials. Formerly Braze™ 401		Compositions %			Melt	Flow
				Ag 40	Cu 30	Zn 30	1245°F 675°C	1340°F 725°C
Product Name	Item #	Description	Case Qty.					
Silvaloy® 401*	98090	1/16" (1.6 mm) Dia. x 1 Troy Oz. Clam Shell	6/Box					



EASY•FLO® 45		Versatile alloy, used for most ferrous and non-ferrous metals. Contains Cadmium, therefore exercise extreme caution as Cadmium fumes are toxic.		AWS Spec	Compositions %				Melt	Flow
				BAg-1	Ag 45	Cu 15	Zn 16	Cd 24	1125°F 607°C	1145°F 618°C
Product Name	Item #	Description	Case Qty.							
Easy Flo® 45	98296	1/16" (1.6 mm) Dia. x 1 Troy Oz. Clam Shell	6/Box							
Easy Flo® 45	98298	1/16" (1.6 mm) Dia. x 5 Troy Oz. Clam Shell	6/Box							
Easy Flo® 45*	98290	3/32" (2.4 mm) Dia x 50 Troy Oz. Knock-out Box	1/Box							
Easy Flo® 45	98295	1/16" (1.6 mm) Dia x 50 Troy Oz. Knock-out Box	1/Box							
Easy Flo® 45*	98305	1/32" (0.8 mm) Dia x 50 Troy Oz. Knock-out Box	1/Box							



SAFETY NOTE: These alloys contain Cadmium. Cadmium fumes are toxic, and as a result, these materials should only be used in well-ventilated areas. For additional information, consult your SDS information or contact our Technical Services Department.



Lead-Bearing Solders

Low-temperature, tin/lead solders available in solid wire or acid core.

50/50		Standard general purpose Tin/Lead solder for moderate joint clearances. Available as Solid, Acid or Rosin core.	
Composition %		Melt	Flow
Sn 50	Pb 50	361°F 183°C	421°F 216°C
Product Name	Item #	Description	Case Qty.
50/50	53137	1/8" Dia x 1 lb Spool	25 lb.

Tin/Antimony Solder

95/5		General purpose Tin/Antimony solder. Not for use on brass alloys.	
ASTM B32 Sb5			
Composition %		Melt	Flow
Sn 95	Sb 5	450°F 233°C	464°F 240°C
Product Name	Item #	Description	Case Qty.
95/5	57263	1/8" Dia x 1# Spool	25 lb.

Product Availability: 1/8" diameter 1 pound spools standard, however other diameters and sizes (including 1/2 lb., 5 lb., 10 lb., 25 lb., 25# spools and bar) are available upon request

Packaging Options: 25 pounds per case (1 lb. spool).

Solder Fluxes

For soldering applications we offer two different flux products depending on the materials to be joined. They include SILVABRITE® 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.).

Product Name	Item #	Description	Case Qty.
Handy® Type TEC Liquid Soldering Flux	97000	4 oz. (113g) Flip Top Squeeze Bottle	24/Box
SILVABRITE® Paste Solder Flux	75108	4 oz. (113g) Brush Cap	24/Box



Silver-Bearing, Lead-Free Soft Solders

High strength—general purpose solders.
Higher strength than Tin/Lead solders and safe for potable water systems.

These alloys are widely used in low-stress, low-pressure copper-copper and copper-steel applications (e.g. sight glasses where temperature must be kept low, etc.). For copper-copper, Silvabrite® Paste Flux is the flux of choice. For copper-steel applications, TEC Liquid Flux is recommended as it is more aggressive at keeping the metal surfaces to be joined free of oxides. TEC is a more corrosive flux however, and subsequent flux residue removal is recommended.



SILVABRITE® ASTM B32 Sn96	Silver/tin soldering alloys engineered specifically for field repair. Specially formulated to make difficult repairs swiftly and confidently. Use for fast melting, free flowing jobs.		Nom. Composition %		Melt	Flow
			Ag 3.6	Sn 96.4	430°F 221°C	430°F 221°C
Product Name	Item #	Description	Case Qty.			
SILVABRITE®	56619	1/8" Dia x 1 lb Spool	25 lb.			

SILVABRITE® S ASTM B32 Sn95	Silvabrite S which contains 4.6% Ag as compared with 3.6% in Silvabrite is ideally suited to applications where the added silver produces a plastic range during melting		Nom. Composition %		Melt	Flow
			Ag 4.6	Sn 95.4	430°F 221°C	473°F 245°C
Product Name	Item #	Description	Case Qty.			
SILVABRITE® S	53113	1/8" Dia x 1 lb Spool	25 lb.			

SILVABRITE® 973	A safe and effective lead free solder for drinking water systems and other application where an environmentally friendly product is preferred		Nom. Composition %		Melt	Flow
			Cu 3.5	Sn 96.5	440°F 225°C	572°F 300°C
Product Name	Item #	Description	Case Qty.			
SILVABRITE® 973	52154	1/8" Dia x 1 lb Spool	25 lb.			

SILVABRITE 100® THE SAFE WATER SOLDER ASTM B32 Grade E	Lead-free and antimony-free, non-toxic solder. Developed as a safe and easy to use solder for drinking water systems and other applications. Suitable for joining copper, steel, stainless steel. Nickel metals and alloys. A low melting point and wide melting range for excellent flow and control.		Nom. Composition %			Melt	Flow
			Ag 0.5	Sn 95.5	Cu 4	440°F 225°C	660°F 349°C
Product Name	Item #	Description	Case Qty.				
SILVABRITE 100®	56761	1/8" Dia x 1 lb Spool	25 lb.				
SILVABRITE 100®*	57110	1/8" Dia x 5 lb Spool	10/Box				
SILVABRITE 100®*	57111	1/8" Dia x 20 lb Spool	1/Box				

SILVABRITE® 6 ASTM B32 Sn94	Lead-free, silver-bearing high-strength solder used for applications requiring large joint clearances. Easiest Silver-bearing soft solder to work with as temperature range permits "bridging" loose fit-ups if necessary.		Nom. Composition %		Melt	Flow
			Ag 5.6	Sn 94.4	430°F 221°C	536°F 280°C
Product Name	Item #	Description	Case Qty.			
SILVABRITE® 6	96010	1/8" Dia x 1 lb Spool	25 lb.			

*Lead Times and Minimums may Apply

HANDY ONE® Aluminum Braze

Flux-cored, low temperature braze for joining aluminum and copper alloys

Flux cored alloy is ideal for brazing aluminum to aluminum or aluminum to copper. Non corrosive flux does not require removal after brazing.



AL 822		Flux Cored Braze	
Composition %		Melt	Flow
Zn 78	Al 22	800°F 426°C	900°F 482°C
Product Name	Item #	Description	Case Qty.
AL 822 Handy One Alum Flux Cored Braze	99088	.090" Dia x 20" x 4 Sticks - Plastic Tube	20/Box

How to Braze Aluminum to Copper

Aluminum Brazing with AL 822

HANDY ONE®

Flux-cored brazing alloys

Handy One is a brazing alloy in strip form that is rolled around a powdered flux. This simplifies and improves the brazing operation by eliminating the separate fluxing operation, and by delivering the correct amount of flux – right where it's needed.

Other benefits include:

- Improves joint strength due to a reduction in flux inclusions
- Reduces brazing cycle time - flux insulates, so less flux means parts heat up to brazing temperature quicker
- Minimizes post braze cleaning



How to Braze Copper to Steel with HANDY ONE®

HANDY ONE®		Flux-cored brazing rods	
Product Name	Item #	Description	Case Qty.
Silvaloy® 505† Handy One Flux Cored	99076	.075" Dia x 20" x 8 Rods - Plastic Tube (1.9 mm x 510 mm)	12/Box

Flux Coated Brazing Rod

For joining ferrous and non-ferrous materials.

In addition to bare and cored high silver brazing alloys, we also offer rods that are coated with our general purpose Handy Flux. We start with 1/16" diameter wire and coat on the flux for a final diameter of 1/8". Rods are 18" in length and product is packaged into 1/4 pound tubes.



The Function and Stages of Flux - Flux as a Temperature Indicator

FLUX COATED		Flux-coated brazing rods	
Product Name	Item #	Description	Case Qty.
Silvaloy® 560† Flux Coated (Orange)	98120	.062" Dia x 18" x 8 Rods - Plastic Tube (1.6 mm x 457 mm)	12/Box
Silvaloy® 505† Flux Coated (White)	98110	.062" Dia x 18" x 8 Rods - Plastic Tube (1.6 mm x 457 mm)	12/Box
Silvaloy® 452† Flux Coated (Blue)	98100	.062" Dia x 18" x 8 Rods - Plastic Tube (1.6 mm x 457 mm)	12/Box

White Flux vs. Black Flux

†Refer to page 4 or 5 for Alloy Composition

*Lead Times and Mins may Apply



Brazing Flux – HANDY FLUX®

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. Where larger mass assemblies are being joined, Black Flux or Handy B1 is often recommended as it offers higher temperature protection.

Handy Flux (White)

Handy Flux conforms to:

Handy Flux Type B-1
(Black-Boron Modified)

AWS A5.31 FB3A
SAE AMS-3410

HANDY FLUX®		Brazing Flux	
Product Name	Item #	Description	Case Qty.
Handy® Flux	97030	7 oz. (.190kg) Jar w/Brush Cap	24/Box
Handy® Flux	97032	1 lb. (.454kg) Jar	24/Box
Handy® Flux	97034	5 lb. (2.27kg) Jar	6/Box
Handy® Flux*	97035	25 lb. (11.35kg) Pail	1 ea.
Handy® Flux*	97036	50 lb. (22.68kg) Pail	1 ea.
Handy® B1 Flux*	97041	Boron Modified - 1 lb. (.454kg) Jar	24/Box
Handy® B1 Flux*	97042	Boron Modified - 5 lb. (2.27kg) Jar	6/Box
Handy® B1 Flux*	97043	Boron Modified - 25 lb. (11.35kg) Pail	1 ea.

Brazing Flux – ULTRA FLUX®

Premium grade general application silver brazing flux. For use on all metals except aluminum, magnesium, and titanium. Fully molten at 1100°F, effective to 1600°F. Like all Lucas Milhaupt fluxes, Ultra Flux is manufactured to the highest quality standards to assure consistently outstanding performance.

Ultra Flux conforms to:

AWS A5.31 FB3A

SAE AMS-3410

Fed Spec O-F-499 Type B



ULTRA FLUX®		Brazing Flux	
Product Name	Item #	Description	Case Qty.
Ultra Flux®	75014	7 oz. (.190kg) Brush Cap	24/Box
Ultra Flux®	75015	1 lb. (.454kg) Jar	24/Box
Ultra Flux®	75016	5 lb. (2.27kg) Jar	6/Box



Brazing Flux – BLACK FLUX™

Black Flux is a boron modified, water based active fluoride/borate-type flux in paste form, which has been specially formulated to give excellent adhesion when dipped or brushed on parts. It is recommended to use with filler metals that flow between 1050°F (565°C) - 1800°F (982°C) and specifically formulated to ensure a creamy consistency. The flux provides excellent protection of parts up to 1800°F (982°C).

Black Flux conforms to:

AWS A5.31 FB3C

SAE AMS-3411

Fed Spec O-F-499D, Type B

BLACK FLUX™		Brazing Flux	
Product Name	Item #	Description	Case Qty.
Black Flux	75020	1 lb. (.454kg) Jar	24/Box
Black Flux	75021	5 lb. (2.27kg) Jar	6/Box

Brazing Tips and Techniques Brochure

An excellent "How To" publication produced by Lucas-Milhaupt that covers a wide variety of topics regarding the nature of brazing. Included is information pertaining to the six brazing fundamentals including proper joint design, clearance, cleaning, brazing techniques and safety information. This book can be ordered individually or in packs of 25.

Pack of 25 - Part # 99092



Counter Mat

A laminated, non-slip foamed back counter mat that includes an easy to read selection guide with a competitive cross reference for the Lucas-Milhaupt brazing and soldering product line. Counter mat is available at no charge with minimal brazing material orders.

Counter Mat - Part # 99200

Point-of-Purchase Display

Suitable for counter top display or hanging on pegboard. It includes a helpful laminated alloy selection guide for use by the trade in selecting the proper alloy and flux for a variety of metal joining applications. Display comes preassembled and is included at no charge with your initial minimum order. And while we recommend a specific stocking mix, product assortment can be customized for your requirements.

POP Display - Part # 99202



SIZE CHART

- = 1/32" (.031") (.8mm)
- = 3/64" (.047") (1.2mm)
- = 1/16" (.062") (1.6mm)
- = 3/32" (.094") (2.4mm)
- = 1/8" (.125") (3.2mm)
- = .075" (1.9mm) (Handy 1)
- = .078" (2mm) (Aluminum Solder)
- = .125" (3.2mm) (Square)
- ▬ = .125" x .050" (Flat Rod)
(3.2mm x 1.27mm)

ATOMIC SYMBOLS

Ag = Silver
 Ni = Nickel
 Sn = Tin
 Cu = Copper
 Cd = Cadmium

P = Phosphorus
 Zn = Zinc
 Al = Aluminum
 Pb = Lead
 Sb = Antimony

WARNING! Brazing can generate potentially harmful fumes and gases. Protect yourself and others. Obtain a Safety Data Sheet (SDS) from your supplier or from Lucas-Milhaupt, Inc. Follow the SDS' instructions for safe brazing practices and appropriate measures.

Bare Metals to be Joined	Filler Metal to be Used	Proper Flux Selection	Comments
COPPER OR BRASS TO COPPER OR BRASS	SOLDER WITH: Silvabrite® 6 Silvabrite® 5 Silvabrite® Silvabrite® 100	Silvabrite® Flux or TEC Flux	Silvabrite® 6 is alloy of choice. It is lead free, contains 5.6% silver and can be made to exhibit either fluid or sluggish characteristics.
	BRAZE WITH: Sil-Fos® 15 Handy Flo® 6 Sil-Fos® 5 Sil-Fos® 2 Fos-Flo® (0% Ag)	These alloys are self-fluxing on copper, but Handy Flux® is needed for brass.	Sil-Fos® 15 is the #1 choice by contractors, due to its greater ductility & ability to absorb vibration stresses, etc. Due to potential for brittle iron-phosphide formation, these alloys are not recommended for brazing steel or other ferrous alloys.
COPPER OR BRASS TO STEEL	SOLDER WITH: Silvabrite® 6 Silvabrite® 5 Silvabrite®	TEC Flux TEC Flux	Silvabrite® 6 used with the more aggressive TEC Liquid Flux is the recommended choice.
	BRAZE WITH: Silvaloy® 560 Silvaloy® 505 Silvaloy® 450 Silvaloy® 401 Silvaloy® 560 Flux Coated or Flux Cored Silvaloy® 505 Flux Coated or Flux Cored Silvaloy® 452 Flux Coated Silvaloy® 380 Flux Cored	Handy Flux® Handy Flux® Handy Flux® Handy Flux®	Silvaloy® 505 is fast becoming the alloy of choice because it offers higher strength, better corrosion resistance and better "wetting" to steel and stainless steel especially.
COPPER OR BRASS OR STEEL TO STAINLESS STEEL	SOLDER WITH: Silvabrite® 6 Silvabrite® 5 Silvabrite®	TEC Flux TEC Flux	Silvabrite® 6 used with the more aggressive TEC Liquid Flux is the recommended choice.
	BRAZE WITH: Silvaloy® 505 Silvaloy® 505 Flux Coated or Flux Cored	Handy Flux®	We always advise using a nickel-bearing alloy to eliminate corrosion. Silvaloy® 505 is an excellent choice
ALUMINUM TO ALUMINIUM OR COPPER	AL-822 Flux Cored Aluminum Braze		High strength, low temperature braze for joining aluminum to aluminum, and aluminum to copper. Easy to use, contains a non-corrosive flux.



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