

Technical Data Sheet

45 Brazing Alloy



Cronatron™
A LAWSON BRAND



Overview

The extra-strong, silver-bearing alloy for critical applications where vibration, shock or impact could cause failure in a weld joint. Especially recommended for copper-to-copper and where "something extra" is needed for safety and reliability.



Features/Benefits

- Vibration and shock resistant
- High corrosion resistance
- Excellent electrical conductivity
- Low heat factor allows use in delicate assemblies
- Thin flow qualities excellent for long lap joints and press fit connections
- No flux required in copper applications

Applications

- Copper coils and tubing
- Electrical contacts and lug connectors
- Copper wire splicing, relays and commutators
- Rotor bars and armatures
- Brass and bronze fittings to copper tube or plates

Method of Application

Torch

Identification

Rectangular, silver finish

Directions for Use

Heat broad area using large torch tip. A neutral flame is suggested and a distance of 2" to 3" (5.1cm to 7.6cm) from the base metal produces the best results. No flux is required on copper-to-copper welds. The joint area should be clean. When the copper turns dull red, the alloy should be applied and the flame should be kept in constant motion ahead of the rod. 45 Brazing Alloy is especially effective on long lap joints, fillets and butts.

Technical Specifications

Tensile Strength: 92,000 PSI (634 MPa)
Temperature: 1,300°F to 1,450°F (705°C to 790°C)

Technical Tips

F40 Flux is recommended when bonding copper to dissimilar alloys.

