

Crown 95 & Crown 95 SFCK

Bare & Flux Cored Alloy for Soldering (S)

Silver-Tin Alloy



"The Royal Line"

CROWN ALLOYS COMPANY

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Low Temperature Silver-Tin Solder

Typical Applications

Crown 95 (solid) is a low temperature, high strength solder for stainless steel, copper, brass, bronze and carbon steel. It is lead and cadmium free. It is excellent for use on food handling equipment since it is Food and Potable Water Safe for dairies, bakeries and restaurants. **Crown 95** creates strong and ductile joints especially on copper and stainless steel (see chart below). It has a high tolerance to vibration and stress. It is also used in plumbing, refrigeration, dental and surgical instruments and high intensity lamps. **Crown 95** is superior to all other solders for general maintenance and repair applications.

Specifications

- Silver 3.50%
- Tin 96.5%
- Solidus 430°F
- Liquidus 430°F
- Corrosion Resistance Very Good
- Color Stays bright and shiny
- Shear Strength up to 11,600 psi
- Elongation 48%
- Electrical Conductivity (%IACS) 16.4%
- Tensile Strength (copper) up to 15,000 psi*
- Tensile Strength (stainless steel) up to 25,000 psi*

*Joint strength is a function of the base metals being joined, type of joint, design of joint, temperature and soldering procedures.

Procedure

Clean joint area. It is helpful to mechanically remove oxides with emery cloth, wire brush, sandblasting, etc. Apply **Crown 95 Flux** to remove more oxides and to facilitate flow of the solder into the joint area (capillary action). Use any heat source that will produce 430°F in the base metal. If a torch is used, heat the base metal indirectly (4 to 6 inches away) to avoid burning the flux. When the flux begins to bubble, drag the **Crown 95** or **Crown 95 SFCK** over the area to be soldered until it begins to flow. If the flux turns black and has been burned, let the area cool, clean it (be sure to use emery cloth) and start over. Allow to cool slowly. Remove flux residue with hot water and a wire brush.

It may be necessary to use an additional amount of the **Crown 95 Flux** with the **Crown 95 SFCK (flux cored)** if the base alloy is particularly dirty or heavily oxidized.

Sizes and Part Numbers

Product	Diameter	Part Numbers
		1 lb spool
Crown 95 (bare)	1/16	LS95/1L
	3/32	LS95/1N
	1/8	LS95/1O
Crown 95 SFCK (flux cored)	1/16	LS95FC/1L
	1/8	LS95FC/1O



!!!! WARNING !!!!



WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.

BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND THE NEW 16 SECTION SAFETY DATA SHEET (SDS).

THE SAFETY DATA SHEET (SDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE SDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.

DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE SDS.

SEE THE PRODUCT WARNING LABEL AND SDS FOR COMPLETE WARNING INFORMATION.

