

Crown Sil 45 & Sil 45FC

Bare & Flux Coated Rod for Torch Brazing (TB)

Silver Alloy



"The Royal Line"

CROWN ALLOYS COMPANY

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Cadmium Free Thin Flowing Silver Alloy

Typical Applications

Crown 45% silver alloy is used for all ferrous and non-ferrous metals except the white metals (aluminum and magnesium). Used for high strength close fit up joints on drill bits, tool tips, contact points, etc. It is used in the dairy and food industries where the use of cadmium is prohibited. This 45% silver alloy is often used in the electrical industry and for brazing parts such as brass pipe or copper tube, band instruments, lamps, etc. **Crown Sil 45FC** is pre-fluxed with just the right amount of flux. This very convenient alloy requires no dipping or preparatory work. **Crown Sil 45 and Sil 45FC** have a maximum recommended operating temperature of 400°F for continued service and up to 600°F for intermittent service.

Specifications

AWS A 5.8
BAg-5

- Silver 44.0 – 46.0%
- Copper 29.0 – 31.0%
- Zinc 23.0 – 27.0%

- Solidus 1225°F
- Liquidus 1370°F
- Brazing Range 1370 – 1550°F

Procedure

Clean work surface. Remove dirt, grease, and rust from joint area. When using the bare **Sil 45**, apply **Crown 45 Flux** to joint. Heat joint until flux liquefies and apply silver. Keep torch moving around joint until silver flows out completely. When using **Crown Sil 55FC**, melt off a little flux onto work first and follow procedure as above.

Sizes and Part Numbers

Product	Diameter	Part Numbers	
		1 ounce package	16 ounce standard pkg.
Crown Sil 45 (bare) <u>18"</u> Length	1/16 x 18"	LS45/EL-BP	LS45/EL
	3/32 x 18"	LS45/EN-BP	LS45/EN
Crown Sil 45 (bare) <u>Coil</u>	1/32 x coil	LS45/CJ-BP	LS45/CJ
	3/64 x coil	LS45/CK-BP	LS45/CK
	1/16 x coil	LS45/CL-BP	LS45/CL
	3/32 x coil	LS45/CN-BP	LS45/CN
Crown Sil 45FC (flux coated) <u>18"</u> Length	1/16 x 18"	LS45F/EL-BP	LS45F/EL
	3/32 x 18"	LS45F/EN-BP	LS45F/EN



!!!! 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.

