

Crown Sil 55 & Sil 55FC

Bare & Flux Coated Rod for Torch Brazing (TB)

Silver Alloy



"The Royal Line"

CROWN ALLOYS COMPANY

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Cadmium Free, High Silver Alloy

Typical Applications

Crown 56% Silver Alloy is safe for use on all food handling equipment which is often found in restaurants, hospitals, dairies, bakeries, etc. This silver alloy is also used in industrial applications including tool and die work. It can be used on all ferrous and non-ferrous (copper, brass and bronze) metals except the white metals (aluminum and magnesium). This 56% silver alloy melts at a lower temperature than the 45% silver alloy and is therefore well suited for brazing stainless steel, nickel or nickel alloys where stress cracking can occur at higher temperatures. 56% silver alloys also provide good color match on stainless steels, nickel and nickel alloys due to its whitish color. The **Crown Sil 55FC** is pre-fluxed with just the right amount of flux. This very convenient alloy requires no dipping or preparatory work. **Crown Sil 55 and Sil 55FC** 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-7

• Silver	55.0 - 57.0%
• Copper	21.0 - 23.0%
• Zinc	15.0 - 19.0%
• Tin	4.5 - 5.5%
• Tensile Strength	66,000 psi (typical)
• Solidus	1145°F
• Liquidus	1200°F
• Brazing Range	1205 - 1400°F

Procedure

Clean work surface. Joint clearances of 0.001 to 0.005 inches are recommended for proper capillary action. Remove dirt, grease, and rust from joint area. When using the bare **Sil 55**, 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 55 (bare) <u>18"</u> Length	1/16 x 18"	LS55/EL-BP	LS55/EL
	3/32 x 18"	LS55/EN-BP	LS55/EN
Crown Sil 55 (bare) <u>Coil</u>	3/64 x coil	LS55/CK-BP	LS55/CK
	1/16 x coil	LS55/CL-BP	LS55/CL
	3/32 x coil	LS55/CN-BP	LS55/CN
Crown Sil 55FC (flux coated) <u>18"</u> Length	1/16 x 18"	LS55F/EL-BP	LS55F/EL
	3/32 x 18"	LS55F/EN-BP	LS55F/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.

