

Royal 100

Bare Rod for Gas Brazing (TB)

Aluminum Alloy



"The Royal Line"

CROWN ALLOYS COMPANY

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Premium High Strength Thin Flowing Aluminum Brazing Alloy For Torch

Typical Applications

Royal 100 is recommended for brazing thin sheets, extruded shapes and corner joints on aluminum. Used in both production and maintenance applications when thin flow and capillary action are helpful. **Royal 100** can not be anodized.

Specifications

- Working Temperature 1075°F
- Tensile Strength Up to 35,000 PSI
- Yield Strength Up to 28,000 PSI
- Color Match Excellent
- Electrical Conductivity Good
- Corrosion Resistance Good

Procedure

The joint area must have a close tolerance and must be clean and free from oxides. It is usually best to remove the tough aluminum oxides with a clean stainless steel wire brush. The stainless steel wire brush must be either brand new or dedicated for aluminum only. Use **Crown 100 Flux** either as a powder or mixed with water or alcohol to form a paste. Heat with a carburizing flame keeping the torch in constant motion until the flux turns to a clear liquid. Apply alloy. The capillary action of the **Royal 100** will cause it to flow freely through the joint, following the heat of the flame. Remove flux residue by quenching and washing in hot water.

Sizes and Part Numbers

Diameter	Part Numbers	
	1# Package	3# Package
1/16 x 18"	RT100/TL-BP	RT100/TL
3/32 x 18"	RT100/TN-BP	RT100/TN
1/8 x 18"	RT100/TO-BP	RT100/TO



!!!! 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.

