

Crown Sil 50 Ni

Bare Rod for Torch Brazing (TB)

Silver Alloy



"The Royal Line"

CROWN ALLOYS COMPANY

30105 Stephenson Hwy, Madison Heights, MI 48071
(248) 588-3790 (800) 521-7878 www.crownalloys.com

Cadmium Free, Thin Flowing High Strength Silver Alloy

Typical Applications

Because of the small addition of nickel, the **Crown Sil 50 Ni** is the best silver alloy for joining tungsten carbide inserts to steel in cutting tools. It is recommended for joining 300 Series stainless steel and will retard interface corrosion. Because the **Crown Sil 50 Ni** is cadmium-free, it can be safely used on food handling equipment, hospital utensils and dental instruments. The **Crown Sil 50 Ni** will also join beryllium copper and aluminum bronze to steel. The small addition of nickel to the **Crown Sil 50 Ni** increases its corrosion resistance well above standard silver alloys.

Specifications

AWS A 5.8/A5.8M
BAg-24

- Silver 49.0 - 51.0%
- Copper 19.0 - 21.0%
- Zinc 26.0 - 30.0%
- Nickel 1.5 - 2.5%

- Tensile Strength 70,000 psi (typical)
- Liquidus 1305°F
- Solidus 1220°F
- Brazing Range 1310°F – 1550°F

Procedure

Clean joint area thoroughly.

Apply a liberal amount of **Crown 45 Flux (white paste flux)**. Heat parts until flux turns to clear liquid. Add a small amount of **Crown Sil 50 Ni** and pull it through the joint with the torch.

Crown Sil 50 Ni is very fluid at its liquidus temperature and will quickly fill long, narrow joints. Make sure to heat the **Crown Sil 50 Ni** quickly through its melting range.

When joining tungsten carbide inserts to cutting tools, keep most of the heat on the tool to keep from cracking the carbide.

When brazing on thicker material or larger tungsten carbide inserts that require more prolonged heating, use any **black paste flux**. This black flux has a higher active temperature range (1050°F-1800°F) than the **Crown 45 Flux** (1000°F-1600°F).

Sizes and Part Numbers

Diameter	Part Numbers	
	1 ounce package	16 ounce standard package
3/64 x coil	LS50N/CK-BP	LS50N/CK
1/16 x coil	LS50N/CL-BP	LS50N/CL



!!!! 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.

