



## HH 1018 FC NICKEL SILVER BRAZING

### JOINING ALLOY FOR USE WITH TORCH

#### General Characteristics

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HH 1018 FC is a unique ultra high purity nickel silver alloy with a special flux coating that eliminated harsh chemical odors and the bright glare that conventional type nickel silver normally offers. It has a slick, smooth moisture sealed flux that has triple the life of normal products of the same type. The flux cleaning action is exceptional on dirty steels and cast irons. This high strength joining alloy is used where thin flow joints are required.

#### Procedure

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Clean the weld zone of all contaminants. A rough ground surface will produce the best results. This flux coated alloy does not need extra flux and will break down tough oxides that normally form. Always use a neutral flame concentrating on the base metal and not the rod. Keep the torch in constant motion to prevent overheating of local areas. When using this product as a joining alloy, use the smallest size, which will help with thin flowing in the joint area. Allow part to cool slowly when done, and remove flux with a stainless steel wire brush.

#### Application

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HH 1018 FC is excellent for close fitting joints on broken drills, mill cutters, steel furniture and bicycle assemblies. Also excellent for attaching carbide cutting bits as a low cost substitute for silver alloys, or wherever high strength joints is required. This alloy can be used to join carbide steel, alloy steel, cast iron, and numerous nonferrous materials to themselves, or multiple combinations. (Not to be used for the white metals)

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Tensile Strength	102,000 PSI
Yield Strength	90,000 PSI
Elongation	28%
Hardness	210 Brinell
Hardness (Work Hardened)	265 Brinell
Melting Point	1583-1640° F
Working Temperature	1595° F
Remelt Temperature	1800° F

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Diameter	(Inch)	1/16	3/32	1/8
	(mm)	1.5	2.5	3.25