

QUICK REFERENCE CHART

BARE METALS TO BE JOINED	FILLER METAL TO BE USED	PROPER FLUX SELECTION	COMMENTS
COPPER OR BRASS TO COPPER OR BRASS	SOLDER WITH: Silvabrite® 6 Silvabrite® S Silvabrite® Silvabrite® 100	Silvabrite® Flux or TEC Flux	Silvabrite® 6 is alloy of choice. It is lead free, contains 6% silver and can be made to exhibit either fluid or sluggish characteristics.
	BRAZE WITH: Sil-Fos® 15 Handy Flo® 6 Sil-Fos® 5 Sil-Fos® 2 Fos-Flo® (0% Ag)	These alloys are self-fluxing on copper, but Handy Flux® is needed for brass.	Sil-Fos® 15 is the #1 choice by contractors, due to its greater ductility & ability to absorb vibration stresses, etc. Due to potential for brittle ironphosphide formation, these alloys are not recommended for brazing steel or other ferrous alloys.
COPPER OR BRASS TO STEEL	SOLDER WITH: Silvabrite® 6 Silvabrite® S Silvabrite®	TEC Flux TEC Flux	Silvabrite® 6 used with the more aggressive TEC Liquid Flux is the recommended choice. Silvaloy® 505 is fast becoming the alloy of choice because it offers higher strength, better corrosion resistance and better “wetting” to steel and stainless steel especially.
	BRAZE WITH: Silvaloy® 560 Silvaloy® 505 Silvaloy® 450 Silvaloy® 401	Handy Flux® Handy Flux® Handy Flux® Handy Flux	
COPPER OR BRASS OR STEEL TO STAINLESS STEEL	SOLDER WITH: Silvabrite® 6 Silvabrite® S Silvabrite®	TEC Flux TEC Flux	Silvabrite® 6 used with the more aggressive TEC Liquid Flux is the recommended choice. We always advise using a nickelbearing alloy to eliminate corrosion. Silvaloy® 505 is an excellent choice
	BRAZE WITH: Silvaloy® 505	Handy Flux®	
Silvaloy® 505 Flux Coated or Flux Cored			
ALUMINUM TO ALUMINIUM OR COPPER	AL-822 Flux Cored Aluminum Braze		High strength, low temperature braze for joining aluminum to aluminum, and aluminium to copper. Easy to use, contains a non-corrosive flux.