

SLIK-SIL™ 104

CADMIUM FREE, PREMIUM HIGH STRENGTH, SUPER ACTIVE, FLUX COATED, SILVER BRAZE TORCH, FURNACE, INDUCTION

General Characteristics

The exclusive Slik-Sil™ Thermal Flux Coating* is the most active flux on the market today. Slik-Sil™ 104 has excellent wetting action on a wide range of metals, especially stainless steels and carbides. This alloy is cadmium free, non-toxic and easier to use due to the elimination of the glare in the flame. Slik-Sil™ 104 is the most economical substitute for the higher silver alloys.

Applications

With the absence of cadmium, Slik-Sil™ 104 is perfect for the food and drug industries. Use it to join similar and dissimilar metals such as copper, nickel, stainless steel, brass, bronze, Inconel® and Monel®. Excellent for carbides, light gauge metals, heat-treated parts and tight-fitting joints. Color is silver to light yellow, similar to polished brass.

Technical Data

Tensile Strength	up to 73,000 psi (503 N/mm ²)	
Working Temperature.....	approx. 1275°F (690°C)	
Elongation %	approx. 24	
Corrosion Resistance.....	good	
Diameter (in)	1/16	3/32
(mm).....	1.6	2.4

Procedures

Prepare surfaces to be joined by mechanical or chemical cleaning. Fixture parts to maintain alignment. Joint clearance should not exceed .003". Heat parts uniformly with a slightly carburizing flame. Place Slik-Sil™ thermal flux directly on the heated joint. When the flux becomes clear and fluid, melt a small amount of alloy onto the joint and continue heating to uniformly spread the alloy through the entire joint area. **DO NOT OVERHEAT THE BASE METAL.** Allow the part to cool slowly, then remove flux residue with warm water.

*Bare rod and flux is available as Slik-Sil™ 114. Use with Slik-Sil™ Flux for regular applications or MG High Therm Flux for high heat applications.

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