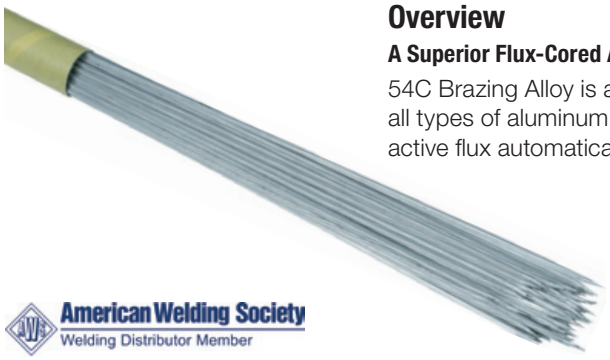
Technical Data Sheet
54C Brazing Alloy

TDS

Cronatron™ A LAWSON BRAND



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Overview

A Superior Flux-Cored Aluminum Brazing Alloy

54C Brazing Alloy is a unique, low-temperature, super-strength aluminum alloy for torch brazing all types of aluminum alloys, castings, extrusions, sheet and wrought alloys. Its core of super-active flux automatically dispenses the proper amount of flux for the job.

Features/Benefits

- Super-easy to use
- Alloy automatically dispenses flux
- No dipping – saves time
- Excellent for joining and buildup
- Rod automatically seals itself – keeps flux fresh
- Superior results on all types of aluminum

Applications

- Truck bodies
- Transmission housings
- Tubing and pipe
- Building up bosses
- Window frames
- Guard rails
- Housings
- Ornamental aluminum

Method of Application

Oxyacetylene torch

Identification

Aluminum gray, flux-cored

Directions for Use

Bevel heavy sections to allow 100% weld metal penetration. Broadly heat area to be brazed with a large, soft and slightly carburizing flame to about 1,050°F (566°C). Warm the end of the rod and rub on base metal until flux flows freely. 54C will then begin to wet the base metal. Deposit the 54C to fill the joint. Flux residue may be removed with warm water and brush.

Technical Specifications

Tensile Strength: 34,500 PSI (238 MPa)
Temperature: 1,100°F (593°C)

Technical Tips

On large sections, preheat to 500°F (260°C) using a temperature-indicating crayon. A stainless steel brush is best for cleaning prior to brazing. If extra flux is required, use F56 Flux.