

MAGNA 66F

Product Description

Magna 66F Flux-Coated Silver Alloy for Maintenance is a “All-Purpose” high silver content brazing rod that bonds well to almost all ferrous and non-ferrous metals. It has a flexible orange flux coating, eliminating the procedure of pasting welding flux that is potentially corrosive. Its outstanding capillary action ensures that the melted alloy can penetrate any joints with tight clearance.



MAGNA 66F is wrapped with a highly flexible orange flux coating

All-Purpose Silver Brazing Alloy

Magna 66F is a cost-effective brazing alloy specially designed for maintenance applications. It produces strong joints quickly and easily on virtually all ferrous and non-ferrous metals including copper, bronze, brass, mid steel, stainless steel, medium / high carbon steel, etc. (except white metals such as aluminum and magnesium). Magna 66F offers you “like new” repaired parts and components both internally and externally. Its excellent tensile strength and ductility with low melting temperature ensures that the repair jobs meet the maintenance professionals’ and engineers’ demanding requirement without failure and that the chemical & physical properties of base metals are not damaged. Consequently, maintenance professionals can reduce the costs of replacing parts and components and risk of unexpected downtime.

Instead of carrying different brazing alloys for different applications, now maintenance professionals can simply stock one item – Magna 66F and forget about other ordinary alloys. As a result, Magna 66F saves the maintenance professionals time and money allocated to maintain adequate stocks of brazing rods.

Flexible Orange Flux-Coating

Formulated with precise Flux-Alloy ratio, Magna 66F’s flux-coating provides welders the convenience bare rods cannot afford. Welders no longer need to worry about protecting the flux from contamination, carrying or placing the extra flux jars, looking for water source to mix the welding flux which is potentially corrosive, applying “just enough” flux to the joints, adjusting & re-adjusting your torch to heat up the flux and overheating the joints while applying the flux. With flux-coated Magna

66F, welders can now go straight to their brazing joints and finish their jobs quickly (Welders can easily remove the flux residues by scrubbing with tooth brush and then rinsing with hot water). Ultimately, Magna 66F reduces the waste of flux, brazing time and flame effluents.

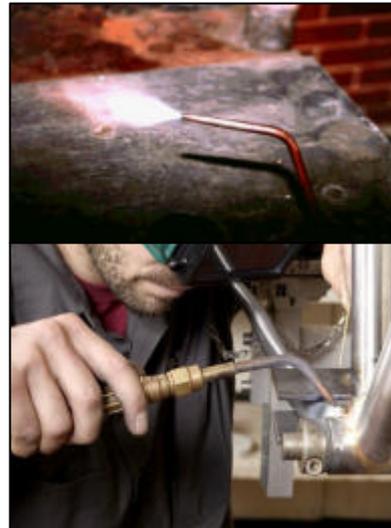
Exceptional Capillary Action

Usually, lap joint clearances are narrow. Good penetrating capability is important for all brazing alloys. Magna 66F's exceptional capillary action allows it to penetrate even the tightest clearance to form strong and reliable joints. In addition, it can join dissimilar metals with different cross-sections or thickness. Ideally for Magna 66F, similar to Magna 66, the joint clearance should be 0.05 to 0.15mm (0.02" to 0.006").

RECOMMENDED APPLICATIONS

- Use oxy-acetylene torch
- Clean and degrease area to be welded
- No need to prepare flux
- Apply Magna 66F and allow heat in base metal to flow the molten Magna 66F alloy into the joint clearance
- Can be used to join most ferrous & non-ferrous metals excluding white metals (e.g. aluminum, magnesium, zinc, etc.) with tight joint clearances at low bonding temperatures
- Use as a all-purpose maintenance silver brazing alloy on -

Brass Fittings / Bronze Castings / Copper Pipes / Plumbing Parts / Rotors / Tool Dies & many more metallic parts or components



NOTE: Magna 66F contains Cadmium. As good brazing practice, apply Magna 66F in a well ventilated area and avoid overheating!!

TYPICAL PRODUCT DATA

Melting Range, °C (°F)	607 to 618 (1124 to 1144)
Tensile Strength	67,000psi

Product dimensions:

Diameter	1.6 mm (1/16 inches)
Pack-size	200 gm pack

PRECAUTION

For complete safety and handling information, please refer to the appropriate Material Safety Data Sheets prior to using this product.

Warranty: Magna Industrial Co. Limited will replace any material found to be defective. Because the storage, handling and application of this material are beyond our control we can accept no liability for the results obtained.

Disclaimer: All information on this data sheet is based on laboratory testing and is not intended for design purposes. Magna Industrial Co. Limited makes no representations or warranties of any kind concerning this data.