



Lehami 7067F

**Super active flux coated cadmium free
silver brazing alloy with 45% silver content**

SPECIAL FEATURES

- Special "Fast Flow" flux coating provides twice the base metal cleansing action of conventional silver flux coatings.
- No odors from rubberized compounds yet the flux coating is totally flexible and non-fragile.
- The only flux-coated silver alloy strong enough to clean and bond oxidized stainless steel

APPLICATIONS

Low temperature joining of dissimilar metals. Excellent where tolerances and fit are not perfect.

TORCH SETTING:

Slightly carburizing

APPLICATION TECHNIQUES:

After cleaning metal, preheat generally to 350°F (200°C) then heat the joint area to 800°F (420°C). Melt off some flux and allow it to flow throughout the joint. Then add the alloy.

TEMPERATURE RANGES

<i>Working Temperature</i>	1245°F (674°C)
Melting Ranges	1175°F (639°C) Solidus
	1235°F (670°C) Liquidus

INTERNATIONAL SPECIFICATIONS	AWS/ASME A5.8 BAg-5
	DIN 8513 L Ag44

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Tensile Strength	68,000 psi (465 N / mm ²)
Yield Strength	54,000 psi (372 N / mm ²)
Elongation	25%
Conductivity	13.5 S
Density	9.49 g / cm ³
Brinell Hardness	120

FLUX COLOR: Orange

DEPOSITION RATES

<i>Diameter</i>	<i>Length</i>	<i>Weldmetal / Rod</i>	<i>Joint Length / 1" (25 mm) of Rod</i>
1/16 (1.6mm)	18" (450 mm)	0.33 oz (9.2 g)	24" (600mm)
3/32" (2.5 mm)	18" (450 mm)	0.65 oz (18 g)	44" (1100mm)

WELD METAL ANALYSIS (Typical Weight %)

Ag	Cu	Zn
44-45	30-31	25-26

ROD PACKAGING & DIMENSIONS:

<i>Diameter</i>	<i>Length</i>	<i>No. of Rods / lb</i>	<i>No. of Rods / kg</i>	<i>No. of Feet / lb</i>	<i>Cm / kg</i>
1/16" (1.6 mm)	18" (450 mm)	32	70	48	3150
3/32" (2.5mm)	18" (450 mm)	16	35	24	1575