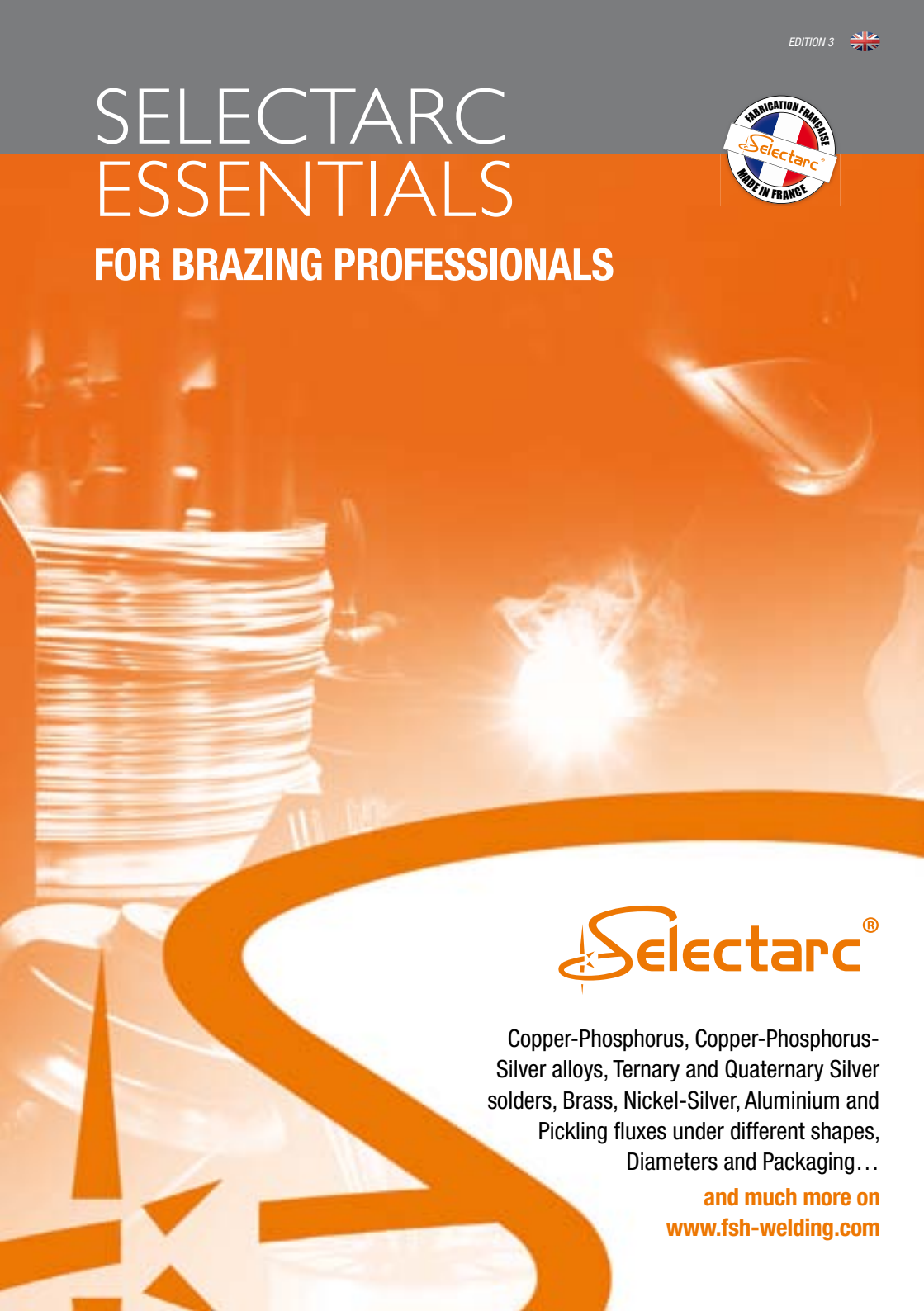
EDITION 3

SELECTARC ESSENTIALS

FOR BRAZING PROFESSIONALS



Selectarc®

Copper-Phosphorus, Copper-Phosphorus-Silver alloys, Ternary and Quaternary Silver solders, Brass, Nickel-Silver, Aluminium and Pickling fluxes under different shapes, Diameters and Packaging…

and much more on www.fsh-welding.com

FSH WELDING GROUP

INNOVATIVE WELDING CONSUMABLES

THE ONLY FOUNDRY
OF BRAZING FILLER METALS
IN FRANCE AND THE PIONEER OF
COPPER-PHOSPHORUS ALLOYS!

FSH WELDING GROUP makes it's every effort to ensure that its customers fully benefit from its large know-how. Since 1948, Reboud-Roche, the brazing manufacturing division of the Group, has acquired recognised expertise, allowing it to be distinguished amongst the major players in the industry and distribution in France. The irreproachable quality of its standard and tailor-made products, as well as its quality assurance process, guarantee compliance with customer specifications.

Our objective is simple and ambitious: to improve continuously in order to ensure the complete satisfaction of each of our customers.

FABRICATION FRANÇAISE
Selectarc
MADE IN FRANCE

Innovation

Quality **Responsiveness**

Customization Flexibility

...

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WHAT IS BRAZING?

Brazing is a permanent metal-joining process which sets a metal continuity between close-fitting parts by capillary action. Brazing is done by atomic migration of both sides of the pieces to be joined obtained by heating.

It is important to note that, unlike welding, there is no melting of base metals. Only the filler metal melt and flow over the base metal (wetting).

Brazing is widely used as an assembly technique in all industries and in building trade.

Selectarc BRAZING

SELECTION OF BRAZING ALLOY FOR SIMILAR & DISSIMILAR JOINTS

BASIC METAL	STEEL	ALUMINIUM	COPPER	CAST IRON *(SLOW PREHEATING AND COOLING)*	STAINLESS STEEL	BRASS	GALVANIZED STEEL	NICKEL
NICKEL	BRAZARGENT 5040* BRAZARGENT 5056*	-	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*
GALVANIZED STEEL	CUPROX FC BRAZARGENT 1520Si*	ZINAL 4 TBW HARASIL NC 12 TBW	CUPROX FC BRAZARGENT 5034*	CUPROX FC BRAZARGENT 5034*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5034* BRAZARGENT 5040*	CUPROX FC BRAZARGENT 5034*	
BRASS	BRAZARGENT 5034* BRAZARGENT 5040*	ZINAL 4 TBW HARASIL NC 12 TBW	BRAZARGENT 5034* PHOSBRAZ AG100 FC	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5034* PHOSBRAZ AG100 FC		
STAINLESS STEEL	BRAZARGENT 5040* BRAZARGENT 5056*	ZINAL 4 TBW HARASIL NC 12 TBW	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*	BRAZARGENT 5040* BRAZARGENT 5056*			
CAST IRON *(SLOW PREHEATING AND COOLING)*	CUPROX FC BRAZARGENT 5040*	-	CUPROX FC BRAZARGENT 5040*	CUPROX FC BRAZARGENT 5040*				
COPPER	CUPROX FC BRAZARGENT 1520Si*	ZINAL 4 TBW HARASIL NC 12 TBW	PHOSBRAZ M70 *(standard joining)* PHOSBRAZ M60 *(special for pitting)*					
ALUMINIUM	ZINAL 4 TBW HARASIL NC 12 TBW	ZINAL 4 TBW HARASIL NC 12 TBW						
STEEL	CUPROX FC BRAZARGENT 1520Si*							

REF.* : To be used with AG-FLUX, as flux coated rods, or as TBW

REF. : flux cored or self-fluxing alloy

CONTENTS

BRAZING ALLOYS

Alloys: *Copper-Phosphorus, Copper-Phosphorus-Silver, Braze-welding alloys, Silver brazing alloys, Aluminium alloys, Flux.*

VIEW OUR FULL RANGE ON WWW.FSH-WELDING.COM

For more information, see our technical data sheets at: *www.fsh-welding.com/en/datasheets.htm*

View our full range on www.fsh-welding.com!

COPPER-PHOSPHORUS ALLOYS

Special range **sparkling free** for great ease in manual applications. This range was invented by André REBOUD, creator of Reboud-Roche plant.

CHOICE

■ **Oven range:**
Consult our technical department.

PHOSBRAZ M60	PHOSBRAZ M70	PHOSBRAZ E80+
★ Low fluidity ★ Wide gaps up to 2 mm	★ Standard fluidity ★ Standard gap	★ High fluidity ★ Very small gap

■ PHOSBRAZ M60

SPECIAL FITTING / COPPER

Selectarc BRAZING

Alloy recommended for large gap joining, **low fluidity**, self-fluxing on red coppers (without addition of flux).

- **Standard colour:** copper.
- **Brazable grades:** Coppers.

MAIN APPLICATIONS

★ Brazing of Copper-Copper connections, mainly in plumbing industry.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
BARE	2.0	500	1	M6B20500R T18O
			5	M6B20500R T20O
BARE	3.0	500	1	M6B30500R T18O
			5	M6B30500R T20O

PRODUCT ADVANTAGES:

- Low fluidity
- Good control in joint filling
- « Flexible » alloy
- Ideal for wide gaps up to 2 mm

ISO 17672 CuP 179 | DIN 8513 L-Cu P6

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION

PHOSBRAZ M70

UNDER CONTROL FLUIDITY / COPPER

Selectarc BRAZING

Alloy recommended for standard joining (sleeves-fittings). **Good fluidity.** Self-fluxing on red coppers (without using flux).

- **Standard colour:** copper.
- **Brazable grades:** Coppers.

MAIN APPLICATIONS

★ Brazing of Copper-Copper connections, principally in the plumbing field.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
BARE	2.0	500	1	M70B20500R T18O
			5	M70B20500R T20O
BARE	3.0	500	1	M70B30500R T18O
			5	M70B30500R T20O

PRODUCT ADVANTAGES:

- Good fluidity
- High speed working
- Universal alloy in plumbing

ISO 17672	DIN 8513	AWS A5.8
CuP 180	L-Cu P7	B Cu-P 2

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE · INDUCTION

PHOSBRAZ E80+

EXCELLENT FLUIDITY / COPPER

Selectarc BRAZING

Alloy recommended for small gaps with deep & close overlap between tubes. **Product with high fluidity.** Self-fluxing on red coppers (without addition of flux).

- **Standard colour:** copper.
- **Brazable grades:** Coppers.

MAIN APPLICATIONS

★ Brazing of copper to copper and copper to brass connections, mainly in plumbing.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
BARE	2.0	500	1	E8+B20500R T18O
			5	E8+B20500R T20O
BARE	3.0	500	1	E8+B30500R T18O
			5	E8+B30500R T20O

PRODUCT ADVANTAGES:

- High capillarity on small gaps
- Low brazing temperatures
- Big overlaps
- Can be used with an aero-propane flame*

ISO 17672	DIN 8513
CuP 182	L-Cu P8

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE · INDUCTION · AERO-PROPANE

*Subject to testing, under customer responsibility.

COPPER - PHOSPHORUS - SILVER ALLOYS

CHOICE

PHOSBRAZ AG20+
- ★ Universal
- ★ Economical

PHOSBRAZ AG50+
- ★ Easy to use
- ★ Good resistance to mechanical vibrations

PHOSBRAZ AG60
- ★ Copper pipes

PHOSBRAZ AG100 FLUX COATED
- ★ Copper-Brass assembly
- ★ Excellent technical and economical compromise

PHOSBRAZ AG150
- ★ Electrical connections

PHOSBRAZ AG20+

UNIVERSAL / COPPER 2 % Ag

Selectarc BRAZING

This alloy recommended for standard joining with a **standard fluidity** and is self-fluxing on red coppers. This shade has **2 % Ag in addition to Phosphorus for a better capillarity.**

■ **Brazable grades:** Coppers.

MAIN APPLICATIONS

★ Copper-Copper joining in sleeve coupling and fittings, heat exchangers (hot/cold) and ventilation systems.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
BARE	2.0	500	1	AG20+B20500R T18O
			5	AG20+B20500R T20O
BARE	3.0	500	1	AG20+B30500R T18O
			5	AG20+B30500R T20O

PRODUCT ADVANTAGES:

- Versatile alloy
- Good fluidity
- The most economical of the Copper-Phosphorus-Silver range
- Easy to use

ISO 17672 CuP 280 | AWS A5.8 BCuP-6

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION

PHOSBRAZ AG50+

SPECIAL COLD / VIBRATIONS / COPPER 5% Ag

Selectarc BRAZING

Alloy with **5% Ag** in addition Phosphorus for a better capillarity is recommended for all assemblies and particularly for air conditioning. Its main features are: **good ductility and very good fluidity**.This product is self-fluxing on red coppers.

- **Brazable grades:** Coppers.

MAIN APPLICATIONS

★ Copper-Copper joining in sleeve coupling and fittings, heat exchangers (hot/cold) and ventilation systems and compressors.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
BARE	2.0	500	1	AG50+B20500R T18O
			5	AG50+B20500R T20O
BARE	3.0	500	1	AG50+B30500R T18O
			5	AG50+B30500R T20O

PRODUCT ADVANTAGES:

- Resistance to mechanical vibrations and water hammer, better than a CuP
- Very good fluidity
- Brazing temperature is lower than AG20

ISO 17672 CuP 282 | AWS A5.8 BCuP-7

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION

PHOSBRAZ AG60

PIPING / COPPER 6 % Ag

Selectarc BRAZING

Copper-Phosphorus alloy with **6% Ag** for hard brazing of red coppers. It is recommended for gas systems (except local regulation) and piping systems. It can be used with propane gas*.

- **Standard colour:** copper.
- **Brazable grades:** Coppers.

MAIN APPLICATIONS

★ Piping and combustible gas installations.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
BARE	2.0	500	1	AG60B20500R T18OA
			5	AG60B20500R T20OA
BARE	3.0	500	1	AG60B30500R T18OA
			5	AG60B30500R T20OA

PRODUCT ADVANTAGES:

- High fluidity
- Low melting temperature
- Excellent wetting properties and capillarity

ISO 17672 CuP 283a

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION | AERO-PROPANE

*Subject to testing, under customer responsibility.

PHOSBRAZ AG100

FLUX COATED

NEW PRODUCT

Alloy with **10% Ag** recommended for Copper-Copper joining, Copper alloys (Brass...). Very good fluidity. This alloy of exceptional performance represents the **"Global economic solution" for Copper/Brass assemblies.**

Brazable grades: Copper and Copper alloys (ex: Brass).

COPPER / BRASS ASSEMBLIES 10% Ag

Selectarc BRAZING

MAIN APPLICATIONS

★ Brazing of brass connections on copper piping.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
WHITE COATING	2.0	500	1	AG100E20500B/S25AGT19O (Printed Rods)
			5	AG100E20500B/S25AG T20O (Printed Rods)

PRODUCT ADVANTAGES:

- Alloy ready for use
- Excellent compromise between fluidity & ductibility
- Excellent wetting properties
- Can be used with propane gas*

FLUX EN 1045 FH10

RECOMMENDED HEATING METHOD:

OXY/ACETYLÈNE · AÉRO-PROPANE

*Subject to testing, under customer responsibility.

PHOSBRAZ AG150

Alloy recommended for assembly with intermediary gap. **Standard fluidity**, Self-fluxing on red coppers. **Silver content: 15%.**

Brazable grades: Coppers.

ELECTRICAL CONNECTIONS / COPPER 15% Ag

Selectarc BRAZING

MAIN APPLICATIONS

★ Copper-Copper assemblies, Electric motor production, Electrical connections, air conditioning.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
BARE	2.0	500	1	AG150B20500R T18O
			5	AG150B20500R T20O
BARE	3.0	500	1	AG150B30500R T18O
			5	AG150B30500R T20O

PRODUCT ADVANTAGES:

- Excellent electrical conductivity
- Ductile alloy
- Very good mechanical resistance
- Allows the filling of important gaps

ISO 17672 CuP 284 · DIN 8513 L-Ag 15 P · AWS A5.8 BCuP-5

RECOMMENDED HEATING METHOD:

OXY/ACETYLÈNE · INDUCTION

BRAZE-WELDING

Braze-welding is a strong brazing process in which the joint is done by butt joining with a similar method to fusion welding. In this technique, there is no capillary action, nor smelting of base material like in brazing process.

Generally, braze-welding method is preferable to autogenous welding for steel assembly of unknown grades or poor welding grades.

This is a particularly economical joining technique, which allows quick work, higher than the autogenous welding method for some thickness.

BRAZE-WELDING ALLOYS

CUPROX

FLUX COATED

JOINING AND REPAIR: STEEL, COPPER, CAST IRON

Selectarc BRAZING

Braze-welding alloy-brass type, recommended for steel assembly and Copper alloys. Thanks to the FC, it is an alloy ready to use.

■ **Brazable grades:** Carbon steels, Moulded steels, Copper, Bronze, Nickel, Cast iron (with caution).

MAIN APPLICATIONS

★ Metalwork, Steel piping, Decorative elements for furniture, Pipework, Decorative utensils.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
SIENA CALCINED COATING	2.0	500	1	**CXE20500S/S T19O** (Printed Rods)
			5	**CXE20500S/S T22O** (Printed Rods)

Customized sizes are available.

PRODUCT ADVANTAGES:

- High quality alloy
- Braze-welding universal alloy
- High mechanical resistance
- Good elongation

ISO 17672	DIN 8513	AWS A5.8
~ Cu 471	L CuZn40	~ RCu-Zn C

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE

NICROX 49 C1

FLUX COATED

HIGH RESISTANCE BRAZE-WELDING

Selectarc BRAZING

Braze-welding alloy-nickel-silver type (Cu-Ni-Zn). NICROX 49 C1 is 10% nickel bearing, and has excellent mechanical resistance (higher than CUPROX). Alloy ready to use. It allows a coating type: Chrome or Nickel plating.

■ **Brazable grades:** Carbon steels, Moulded steels, Copper, Carbide, Cast iron (with caution).

MAIN APPLICATIONS

★ Metalwork, bicycle frames, metal furniture, carbide inserts.

Presentation	Ø (mm)	Length (mm)	Kg/case	Ref.
BLUE COATING	2.0	500	1	**NXE20500F/S T19O** (Printed Rods)
			5	**NXE20500F/S T21O** (Printed Rods)

Customized sizes are available.

PRODUCT ADVANTAGES:

- Very good mechanical resistance
- Uniformed deposits
- Alloy ready for use

ISO 17672	DIN 8513	AWS A5.8
Cu 773	L CuNi10Zn42	Rcu-Zn D

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE

SILVER ALLOYS

BRAZING FOR ALL METALS EXCEPT ALUMINIUM

BRAZARGENT 1520Si
- ★ Thick alloy
- ★ Economical / brazing in stages

BRAZARGENT 5034
- ★ Better technical and economical ratio
- ★ Standard fluidity

CHOICE

BRAZARGENT 5040
- ★ Universal brazing
- ★ Good fluidity

BRAZARGENT 5056
- ★ High mechanical characteristics brazing
- ★ Excellent fluidity

BRAZARGENT 1520Si

ECONOMICAL FOR ALL JOINING

Selectarc BRAZING

Ternary alloy with **20% Ag** with a standard fluidity, ideal in similar and dissimilar joints. Its structure allows brazing in stages (reheating). Alloy to be used as bare rods with AG-FLUX or in Flux Coated rods.

■ **Brazable grades:** Carbon steels, Moulded steels, Brass, Bronze, Copper.

MAIN APPLICATIONS
★ Delicate works, Food industry.

Presentation	Ø (mm)	Length (mm)	Kg/ case	Ref.
BARE	1.5	500	0,25	**1520SIB15500N T18O**
			1	**1520SIB15500N T18O**
BARE	2.0	500	0,25	**1520SIB20500N T18O**
			1	**1520SIB20500N T18O**
WHITE COATING*	1.5	500	0,25	**1520SIE15500B/S25A T18O** (Printed Rods)
			1	**1520SIE15500B/S25A T19O** (Printed Rods)
WHITE COATING*	2.0	500	0,25	**1520SIE20500B/S25A T18O** (Printed Rods)
			1	**1520SIE20500B/S25A T19O** (Printed Rods)

**Customized sizes are available.*

PRODUCT ADVANTAGES:

- Recommend for wide gaps filling
- Good ductility
- Better elongation
- Good fillet-forming capabilities

DIN 8513
L-Ag 20

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE · INDUCTION · FOUR/OVEN

BRAZARGENT 5034

BEST TECHNICAL-ECONOMICAL RATIO

Selectarc BRAZING

Universal Quaternary alloy with **34% Ag.** It is recommended for all similar and dissimilar metals. Very good brazing properties. Highly efficient and economical. Alloy to be used as bare rods with AG-FLUX, in Flux Coated rods, or TBW**, in open atmospheric conditions.

■ **Brazable grades:** Ferrous alloys, Copper alloys, Nickel alloys, Stainless steels and Tool steels, except Aluminium alloys.

MAIN APPLICATIONS

★ Household electrical appliances, Sanitary and Food aeras, Medical fluids Transport, Tools, Plumbing, Delicate works...

Presentation	Ø (mm)	Length (mm)	Kg/ case	Ref.
BARE	1.5	500	0,25	**5034B15500N T18O**
			1	**5034B15500N T18O**
BARE	2.0	500	0,25	**5034B20500N T18O**
			1	**5034B20500N T18O**
BLUE COATING	1.5	500	0,25	**5034E15500F/S25AG T18O** (Printed Rods)
			1	**5034E15500F/S25AG T19O** (Printed Rods)
BLUE COATING	2.0	500	0,25	**5034E20500F/S25AG T18O** (Printed Rods)
			1	**5034E20500F/S25AG T19O** (Printed Rods)
TBW	1.5	500	0,25	**5034T15500N T18O**
			1	**5034T15500N T19O**
TBW	2.0	500	0,25	**5034T20500N T18O**
			1	**5034T20500N T18O**

Customized sizes are available.

PRODUCT ADVANTAGES:

- Good fluidity
- Good wetting properties
- Excellent mechanical properties
- Recommend for small gap

*** New technology for an easier use.*

Ask for our leaflet "TBW SILVER"

ISO 17672 Ag 134

DIN 8513 L-Ag 34 Sn

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION | AERO-PROPANE | FOUR/OVEN

**Subject to testing, under customer responsibility.*

BRAZARGENT 5040

UNIVERSAL Ag BRAZING

Selectarc BRAZING

Multi-purpose Quaternary alloy with **40% Ag.** It is recommended for all similar and dissimilar metals. Very good brazing properties and tensile strength quality. Alloy to be used as bare rods with AG-FLUX, in Flux Coated rods, or TBW**, in open atmospheric conditions.

■ **Brazable grades:** Ferrous alloys, Copper alloys, Nickel alloys, Stainless steels and Tool steels, except Aluminium alloys.

MAIN APPLICATIONS

★ Food industry, Medical fluids transport, Tools, Immersion heaters, Cooling systems, Compressors, Delicate works, and art wares…

Presentation	Ø (mm)	Length (mm)	Kg/ case	Ref.
BARE	1.5	500	0,25	**5040B15500N T18O**
			1	**5040B15500N T18O**
BARE	2.0	500	0,25	**5040B20500N T18O**
			1	**5040B20500N T18O**
ORANGE COATING	1.5	500	0,25	**5040E15500O/S25AG T18O** (Printed Rods)
			1	**5040E15500O/S25AG T19O** (Printed Rods)
ORANGE COATING	2.0	500	0,25	**5040E20500O/S25AG T18O** (Printed Rods)
			1	**5040E20500O/S25AG T19O** (Printed Rods)
TBW	1.6	500	0,25	**5040T16500N T18O**
			1	**5040T16500N T19O**
TBW	2.0	500	0,25	**5040T20500N T18O**
			1	**5040T20500N T19O**

Customized sizes are available.

PRODUCT ADVANTAGES:

- Excellent fluidity
- Good corrosion resistance
- Easy to use

*** New technology for an easier use.*

Ask for our leaflet «TBW SILVER»

ISO 17672	DIN 8513	AWS A5.8
Ag 140	L-Ag 40 Sn	BAg-28

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE · INDUCTION · AERO-PROPANE · FOUR/OVEN

*Subject to testing, under customer responsibility.

BRAZARGENT 5056

VERY HIGH MECHANICAL PROPERTIES

Selectarc BRAZING

Quaternary alloy with **56% Ag**, for all high safety assemblies. This shade has the lowest melting point of our BRAZARGENT range. Excellent capillarity and very good brazing joints appearance. Alloy to be used as bare rods with AG-FLUX, in Flux Coated rods, or TBW**, in open atmospheric conditions.

■ **Brazable grades:** Ferrous alloys, Copper alloys, Nickel alloys, Stainless steels and Tool steels, except Aluminium alloys.

MAIN APPLICATIONS

★ Food industry, Medical tools, Cooling systems, Compressors, Specific assemblies, Jewellery...

Presentation	Ø (mm)	Length (mm)	Kg/ case	Ref.
BARE	1.5	500	0,25	**5056B15500N T18O**
			1	**5056B15500N T18O**
BARE	2.0	500	0,25	**5056B20500N T18O**
			1	**5056B20500N T18O**
PINK COATING	1.5	500	0,25	**5056E15500R/S25AG T18O** (Printed Rods)
			1	**5056E15500R/S25AG T19O** (Printed Rods)
PINK COATING	2.0	500	0,25	**5056E20500R/S25AG T18O** (Printed Rods)
			1	**5056E20500R/S25AG T19O** (Printed Rods)
TBW	1.5	500	0,25	**5056T15500N T18O**
			1	**5056T15500N T18O**
TBW	2.0	500	0,25	**5056T20500N T18O**
			1	**5056T20500N T19O**

Customized sizes are available.

PRODUCT ADVANTAGES:

- Excellent fluidity
- High capillarity
- Nice appearance
- Very good elongation

*** New technology for an easier use.*

Ask for our leaflet «TBW SILVER»

ISO 17672 Ag 156

AWS A5.8 BAg-7

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION | AERO-PROPANE* | FOUR/OVEN

*Subject to testing, under customer responsibility.

CERTIGAZ

CERTIFIED ALLOYS FOR GAS APPLICATIONS

PAG60

FRENCH FUEL GAS SYSTEMS 6 %

Selectarc BRAZING

With AG-FLUX n°1530

Copper-Phosphorus brazing alloy with **6 % Ag**, used for hard brazing of red coppers in fuel gas systems and all piping systems. **Alloy certified by CERTIGAZ (French Gas Company).** Alloy to be used as bare rods with AG-FLUX, ATG registration number 1530.

For other countries, please consult your local regulations.

■ **Brazable grades:** Coppers.

MAIN APPLICATIONS

★ Piping and fuel gas installations.

Presentation	Ø (mm)	Length (mm)	Kg /case	Ref.
BARE	2.0	500	1	**P60B20500R/F T18O** (Printed rods)

PRODUCT ADVANTAGES:

- Production according to ATG certification
- Low melting temperature
- Can be used with propane gas

SPECIFICATION ATG B.524-3
CuP 291

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE · INDUCTION · AERO-PROPANE · FOUR/OVEN

*Subject to testing, under customer responsibility.

BRAZARGENT 5000

40% Ag bearing Quaternary alloy, certified by CERTIGAZ (French Gas Company) in combination with AG-FLUX under the registration ATG n°1598. It is recommended for high resistance capillarity brazing of Copper, Brass, Steel connections in fuel gas systems. Thanks to its excellent fluidity, it is suitable for brazing joints with small gap.

For other countries, please consult your local regulations.

■ **Brazable grades:** Ferrous alloys, Copper alloys, Nickel alloys, Stainless steels and Tool steels, except Aluminium alloys.

FRENCH FUEL GAS SYSTEMS 40%

Selectarc BRAZING

With AG-FLUX n°1598

PRODUCT ADVANTAGES:

- Production according ATG certification
- Low melting temperature
- Very good fluidity
- Good corrosion resistance
- Can be used with propane gas

MAIN APPLICATIONS

★ Fuel gas installations.

SPECIFICATION ATG B.524-3
Ag 140

Presentation	Ø (mm)	Length (mm)	Kg /case	Ref.
BARE	2.0	500	1	**5000B20500N/B T18O** (Printed rods)

RECOMMENDED HEATING METHOD:

OXY/ACETYLÈNE | INDUCTION | AÉRO-PROPANE | FOUR/OVEN

Subject to testing, under customer responsibility.




FLUX

AG-FLUX (Paste)

Scouring flux in paste to be used with our BRAZARGENT range (certified by CERTIGAZ, French Gas company) with the registration number ATG N°1530 in combination with our PAG60, and under the registration N°1598 with our BRAZARGENT 5000.

- **Brazable grades:** Carbon steels, Stainless steels, Copper alloys.
- **Available:** in jars of 60 gr and 200 gr.

PICKING FLUX FOR SILVER BRAZING ALLOYS

Selectarc BRAZING

With PAG60 N°1530
With BRAZARGENT 5000 n°1598

PRODUCT ADVANTAGES:

- Pickling Flux without Boric Acid

FLUX EN 1045
FH10

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION | AERO-PROPANE | FOUR/OVEN

*Subject to testing, under customer responsibility.

ALUMINIUM ALLOYS

ZINAL 4 TBW

DISSIMILAR JOININGS

Selectarc BRAZING

Tubular wire with non-corrosive flux at cored and a melting point around 440°C. This alloy is intended to be used to braze Mg-free aluminium with other metals.

■ **Brazable grades:** Aluminium to Copper, Stainless steels, Steels.

MAIN APPLICATIONS

★ Heat exchangers, household electrical appliances, steel-aluminium electric connections, and galvanized-steel-aluminium.

Presentation	Ø (mm)	Kg/case	Ref.
TBW	2.0	1	**ZINAL4T20500 T18O**

Customized sizes are available.

PRODUCT ADVANTAGES:

- Unique tubular technology in the world
- Aluminium-Copper brazing
- Low working temperature
- Unique alloy for dissimilar alloy joining

RECOMMENDED HEATING METHOD:

OXY/ACETYLENE | INDUCTION | AÉRO-PROPANE | FOUR/OVEN

*Subject to testing, under customer responsibility.

HARASIL NC 12 TBW

ALU/ALU ASSEMBLIES

Selectarc BRAZING

Alloy to be used to braze Mg-free aluminium. Seamless tubular wire with non-corrosive flux at cored. Melting Point: 575-585°C

■ **Brazable grades:** Mainly Aluminium and Aluminium-Stainless steels.

Presentation	Ø (mm)	Kg/case	Ref.
TBW	2.0	1	**NC12T20500 T19O**

Customized sizes are available.

PRODUCT ADVANTAGES:

- Good fluidity
- Good capillarity
- Nice appearance

RECOMMENDED HEATING METHOD:

OXY/ACETYLÈNE | INDUCTION | AÉRO-PROPANE | FOUR/OVEN

**Subject to testing, under customer responsibility.*

PACKAGING

SHAPE

■ **Products available as:**

BARE RODS

FLUX-COATED RODS

PREFORMS

BARE RODS, TUBULAR BRAZING RODS, WIRE & PREFORMS

SPOOLS OR COILS

GRADES

■ **Other grades, on requirement.**

■ **Grades under customer specification or customized formulas are available on request.**

See our technical service.

PACKING

■ **Standard according to range.**

Consult us for your specific requests!

Selectarc
by FSH WELDING GROUP

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