

# QUICK REFERENCE CHART

BARE METALS TO BE JOINED	FILLER METAL TO BE USED	PROPER FLUX SELECTION	COMMENTS
<b>COPPER OR BRASS</b>  <b>TO</b>  <b>COPPER OR BRASS</b>	<b>SOLDER WITH:</b> Silvabrite® 6 Silvabrite® S Silvabrite® Silvabrite® 100	Silvabrite® Flux or TEC Flux	<b>Silvabrite® 6</b> is alloy of choice. It is lead free, contains 6% silver and can be made to exhibit either fluid or sluggish characteristics.
	<b>BRAZE WITH:</b> Sil-Fos® 15 Handy Flo® 6 Sil-Fos® 5 Sil-Fos® 2 Fos-Flo® (0% Ag)	These alloys are self-fluxing on copper, but Handy Flux® is needed for brass.	<b>Sil-Fos® 15</b> is the #1 choice by contractors, due to its greater ductility & ability to absorb vibration stresses, etc.  Due to potential for brittle ironphosphide formation, these alloys are not recommended for brazing steel or other ferrous alloys.
<b>COPPER OR BRASS</b>  <b>TO</b>  <b>STEEL</b>	<b>SOLDER WITH:</b> Silvabrite® 6 Silvabrite® S Silvabrite®	TEC Flux TEC Flux	<b>Silvabrite® 6</b> used with the more aggressive <b>TEC Liquid Flux</b> is the recommended choice.
	<b>BRAZE WITH:</b> Silvaloy® 560 Silvaloy® 505 Silvaloy® 450 Silvaloy® 401	Handy Flux® Handy Flux® Handy Flux® Handy Flux	<b>Silvaloy® 505</b> is fast becoming the alloy of choice because it offers higher strength, better corrosion resistance and better “wetting” to steel and stainless steel especially.
<b>COPPER OR BRASS OR STEEL</b>  <b>TO</b>  <b>STAINLESS STEEL</b>	<b>SOLDER WITH:</b> Silvabrite® 6 Silvabrite® S Silvabrite®	TEC Flux TEC Flux	<b>Silvabrite® 6</b> used with the more aggressive <b>TEC Liquid Flux</b> is the recommended choice.
	<b>BRAZE WITH:</b> Silvaloy® 505	Handy Flux®	We always advise using a nickelbearing alloy to eliminate corrosion. <b>Silvaloy® 505</b> is an excellent choice
Silvaloy® 505 Flux Coated or Flux Cored			
<b>ALUMINUM</b>  <b>TO</b>  <b>ALUMINIUM OR COPPER</b>	AL-822 Flux Cored Aluminum Braze		High strength, low temperature braze for joining aluminum to aluminum, and aluminium to copper. Easy to use, contains a non-corrosive flux.