Cast Iron Brazing Alloys

A selection of brazing alloys for joining cast iron and brazing sheet metal.

Superior Advantages

- Solid, dense deposits that can be machined
- Free-flowing for thin lapping and butted metal joining
- No base metal dilution making tough cast iron repairs possible

Applications

- Sheet metal and auto body repairs
- Engine heads and blocks
- Piping, plumbing and pumps
- Gears, sprockets and pulleys

Certanium® Alloys

83F Brazing Alloy

Brass-Bronze-Copper-Cast Iron-Steel

Flux Color: Orange

Tensile Strength: 65,000 PSI

Hardness: 110-120 Brinell

Bonding Temperature: 1,500°F to 1,600°F (815°C to 871°C)

Recommended Flux: 950 (if needed)

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
3/32 x 18	**P14400**	5
1/8 x 18	**P14410**	5

Cronatron Alloys

22 Brazing Alloy

"True Color Match" Cast Iron

Tensile Strength: 53,000 PSI

Hardness: Rc 18-20

Bonding Temperature: 2,300°F (1,260°C)

Recommended Flux: F22

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
3/16 x 20	**CW3062**	5
5/16 x 24	**CW1829**	5

23F Brazing Alloy

Versatile, thin-flowing

Flux Coating Color: Blue

Tensile Strength: Up to 68,000 PSI

Bonding Temperature: 1,400°F to 1,600°F (760°C to 871°C)

Recommended Flux: F21 (if needed)

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
3/32 x 18	**CW1003**	5
1/8 x 18	**CW1002**	5

30F Brazing Alloy

Maximum strength for joining and buildup

Flux Coating Color: Pink

Tensile Strength: 100,000 PSI

Temperature: 1,300°F to 1,600°F (704°C to 871°C)

Recommended Flux: F21 (if needed)

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
1/16 x 18	**CW1836**	5
3/32 x 18	**CW1006**	5
1/8 x 18	**CW1005**	5
3/16 x 18	**CW1004**	5

Aluminum Brazing Alloys

A selection of alloys for joining all types of aluminum.

Cronatron Alloys

Superior Advantages

- Products for joining and buildup
- Easy to apply

Applications

- Aluminum frames
- Tubing and piping
- Ornamental aluminum
- Cast aluminum

52 Brazing Alloy

High-strength, self-fluxing

Tensile Strength: 40,000 PSI

Bond Strength: 28,000 PSI

Application Temperature: 720°F (382°C)

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
1/8 x 18	**CW1735**	2

54C Brazing Alloy

Flux-cored for all types of aluminum

Tensile Strength: 34,500 PSI

Application Temperature: 1,110°F (599°C)

Recommended Flux: F56 (if needed)

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
1/8 x 32	**CW1857**	2

556T TIG Wire

High alloy

Tensile Strength: 45,000 PSI

Yield Strength: 23,000 PSI

Elongation: 14%

Recommended Flux: F56

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
1/16 x 36	**CW3269**	2
3/32 x 36	**CW3270**	2
1/8 x 36	**CW3271**	2

510T TIG Wire

High-strength, all-purpose

Tensile Strength: 35,000 PSI

Recommended Flux: F56

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
1/16 x 36	**CW1016**	2
3/32 x 36	**CW1015**	2
1/8 x 36	**CW1014**	2