



**!!!! WARNING !!!!**



**WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.**

**BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND MATERIAL SAFETY DATA SHEET (MSDS).**

**THE MATERIAL SAFETY DATA SHEET (MSDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE MSDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.**

**DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) AND PRODUCT WARNING STATEMENT.**

**BE SURE TO CONSULT THE LATEST VERSION OF THE MSDS.**

**SEE THE PRODUCT WARNING LABEL AND MSDS FOR COMPLETE WARNING INFORMATION.**



# **CROWN ALLOYS**

## **COMPANY**

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## **Crown Sil 45 - Sil 45FC**

**Cadmium Free Thin Flowing Silver Alloy**

### **Typical Applications:**

Crown 45% silver alloy is used for all ferrous and non-ferrous metals except the white metals (aluminum and magnesium). Used for high strength close fit up joints on drill bits, tool tips, contact points, etc. It is used in the dairy and food industries where the use of cadmium is prohibited. This 45% silver alloy is often used in the electrical industry and for brazing parts such as brass pipe or copper tube, band instruments, lamps, etc. The **Crown Sil 45FC** is pre-fluxed with just the right amount of flux. This very convenient alloy requires no dipping or preparatory work. **Crown Sil 45 and Sil 45FC** have a maximum recommended operating temperature of 400°F for continued service and up to 600°F for intermittent service.

### **Specifications:**

AWS A 5.8  
BAG-5

➤ Silver	44.0-46.0%
➤ Copper	29.0-31.0%
➤ Zinc	23.0-27.0%
➤ Liquidus	1370°F
➤ Solidus	1225°F
➤ Brazing Range	1370-1550°F

### **Procedure:**

Clean work surface. Remove dirt, grease, rust and burns from joint area. Apply **Crown 45 Flux** to joint. Heat joint until flux liquefies and apply silver. Keep torch moving around joint until silver flows out completely. When using **Crown Sil 45FC**, melt off a little flux onto work first and follow procedure above.

### **Sizes:**

#### SIL 45:

1/32 x coil (bare)  
3/64 x coil (bare)  
1/16 x coil & 18" cut length (bare)  
3/32 x coil & 18" cut length (bare)

#### SIL 45FC:

1/16 x 18" cut length (flux coated)  
3/32 x 18" cut length (flux coated)