



**!!!! 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 50 Ni**

**Cadmium Free Thin Flowing High Strength Silver Alloy**

### **Typical Applications:**

**Crown Sil 50 Ni** is the best silver alloy for joining small tungsten carbide inserts to steel in cutting tools. Also used for joining "300" series stainless steels used in the food, medical and dental fields. The **Crown Sil 50 Ni** is also used to join beryllium copper and aluminum bronze to steel. The small addition of nickel to the **Crown Sil 50 Ni** increases its corrosion resistance well above standard silver alloys.

### **Specifications:**

AWS A 5.8  
BAg-24

➤ Silver	49.0-51.0%
➤ Copper	19.0-21.0%
➤ Zinc	26.0-30.0%
➤ Nickel	1.5-2.5%
➤ Tensile Strength	70,000 PSI
➤ Liquidus	1305°F
➤ Solidus	1220°F
➤ Brazing Range	1310-1550°F

### **Procedure:**

Clean joint area thoroughly. Apply liberal amount of **Crown 45 Flux**. Heat parts until flux turns to clear liquid. Add small amount of filler metal and pull it through the joint with the torch. When using on carbide tips, keep most of the heat on tool to keep from cracking carbide.

### **Sizes:**

3/64 x coil  
1/16 x coil