

MG 120

**Strongest low-heat, non-tarnishing, soft solder.
Contains no toxic elements. All heat sources**



GENERAL CHARACTERISTICS:

A high strength silver solder that is free of cadmium, zinc, lead and other impurities. The deposit stays bright and shiny; therefore it has a close color match to stainless steel. Soldered joints have good corrosion resistance and can readily be plated. Also available flux cored, as MG 120A and as paste solder in MG 120 Syringe.

APPLICATIONS:

Commonly used to join a variety of ferrous and non-ferrous metals when higher strengths are required than normally found with conventional solders. Ideal for use on stainless steel, brass, bronze, copper, nickel, nickel alloys and carbon steels. Typical applications are food and dairy equipment, instruments, oxygen lines, sanitary apparatus, and general maintenance repair.

TECHNICAL DATA:

Typical Tensile Strength	Up to 15,000 psi (10 kg/mm ²)
Working Temperature	430°F (221°C)
Corrosion Resistance	Good
Electrical Conductivity	Very good
Availability	Wire and paste form
Hardness	15 HB
Color Match	Excellent on stainless steel

Diameters Available	1/32" (0.8mm)	1/16" (1.6mm)	3/32" (2.4mm)	1/8" (3.2mm)
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PROCEDURE:

Clean joint area. Apply MG 120 F or MG 120 PF flux and heat parts with a soft flame. Apply solder and continue heating until flow-out is complete. Add additional flux if necessary when solder is still molten. When using MG 120 syringe, pre-place before assembly. Put parts together and heat until alloy becomes liquid. Allow to cool slowly and wash flux residue off with warm water.

* Note: For best results, maintain joint clearances between 0.001" and 0.005"