

# MG SLIK-SIL<sup>®</sup> 104FC



***Cadmium free, premium high strength,  
super active, flux coated, silver braze  
torch, furnace, induction***

## **GENERAL CHARACTERISTICS:**

The exclusive Slik-Sil<sup>™</sup> Thermal Flux Coating\* is the most active flux on the market today. Slik-Sil<sup>™</sup> 104 has excellent wetting action on a wide range of metals, especially stainless steels and carbides. This alloy is cadmium free, non-toxic and easier to use due to the elimination of the glare in the flame. Slik-Sil<sup>™</sup> 104 is the most economical substitute for the higher silver alloys.

## **APPLICATIONS:**

Slik-Sil 104 is used to join similar and dissimilar metals such as copper, nickel, stainless steel, brass, bronze, Inconel<sup>®</sup> and Monel<sup>®</sup>. Excellent for carbides, light gauge metals, heat-treated parts and tight-fitting joints. Color is silver to light yellow, similar to polished brass.

## **TECHNICAL DATA:**

|                          |   |
|--------------------------|---|
| Typical Tensile Strength | Up to 73,000 psi (50 kg/mm <sup>2</sup> ) |
| Working Temperature      | Approx. 1260°F-1500°F                     |
| Elongation               | Approx. 24%                               |
| Corrosion Resistance     | Good                                      |
| Color                    | Pale Yellow                               |

|                    |               |               |
|--------------------|---------------|---------------|
| Diameter Available | 1/16" (1.6mm) | 3/32" (2.4mm) |
|--------------------|---------------|---------------|

## **PROCEDURE:**

Prepare surfaces to be joined by mechanical or chemical cleaning. Fixture parts to maintain alignment. Joint clearance should not exceed 0.005". Heat parts uniformly with a slightly carburizing flame. Place Slik-Sil thermal flux directly on the heated joint. When the flux becomes clear and fluid, melt a small amount of alloy onto the joint and continue heating to uniformly spread the alloy through the entire joint area. DO NOT OVERHEAT THE BASE METAL. Allow the part to cool slowly, then remove flux residue by brushing in warm water.

\*Bare rod and flux is available as Slik-Sil<sup>™</sup> 114. Use with Slik-Sil<sup>™</sup> Flux for regular applications or MG High Therm Flux for high heat applications.

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