

MF 11F



MULTI PURPOSE FLUX COATED BRAZING ALLOY

- Versatile gas electrode welds practically all types of metals including cast iron
- Provides easy all-position application
- Ideal for filling the tight crevice joins
- Exceptional flux cleansing action is a welder choice on dirty surfaces



MF 11F

SPECIAL BENEFITS

- **MF 11F** Multi-Purpose Flux-Coated Brazing Alloy provides superb versatility
 - **MF 11F** is ideal for use with tight joint and gap bridging or filling use
 - **MF 11F** -welds practically all types of metals, including cast iron
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OUTSTANDING PROPERTIES

- Joins galvanized iron without damaging sensitive zinc coating
 - Provides superior fluxing action to enable solid bonding on difficult metal combinations
 - Is effective even on rusty or dirty metals
 - High wettability helps to reduce distortion even on thin sections
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APPLICATIONS

MF 11F is versatile but has a special affinity for cast iron, and also gives excellent results with galvanized iron, brass and steel. Can be used effectively on thin metals.

Triple deoxidized bronze brazing alloy with moisture sealed flux coating

- Unique " Safe Vue" flux coating eliminates harsh chemical odors and the bright orange visibility
- Blocks glare of conventional sodium type flux coatings.
- Sleek, smooth moisture sealed flux has tripled the shelf life of similar products.
- Flux cleaning action is exceptional on dirty steels and cast irons.

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RECOMMENDED FOR:

Torch brazing most steels and cast irons.
Especially suited for joining thin sections.

PROPERTIES:

Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Maximum Value Up to:

71,000 psi (490 N/mm²)

64,000 psi (440 N/mm²)

27%

RECOMMENDED TORCH SETTING: Neutral flame

TEMPERATURE RANGES

Working Temperature:

1595°F (878°C)

Melting Range:

1583°F - 1620°F (870°C - 885°C)

WELDING TECHNIQUES:

Ensure that parts to be joined are clean. Pre-heat general area to 700°F (400°C) and then specific area to 1200°F (650°C). Melt off flux and apply alloy.

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