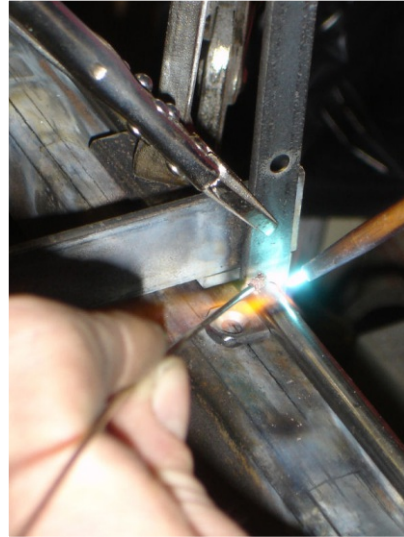


MF 12F

Non-Toxic Flux Coated Silver Alloy for Maintenance



for low temperature high strength joints in the food, medical and pharmaceutical industries.

- **Completely non-toxic - contains no harmful substances**
- **Cadmium free brazing alloy with 56% silver**
- **Highly alloyed for superior weld-ability**
- **Quality flux coating eliminates need for separate supply of flux**



MF 12F

SPECIAL BENEFITS

- MF 12F flux coated silver rod available in 3/64" (1.2mm) diameter for precision work
 - MF 12F Special "Fast Flow" flux coating provides super cleaning action of base metal
 - MF 12F is a unique flux coated silver alloy strong enough to clean oxidized stainless steel
 - MF 12F No odour
 - MF 12F is totally flexible and non-fragile
 - MF 12F is non-toxic ideal for clean environment applications, including food processing and medical institutions
 - MF 12F flows easily due to its superior highly alloyed make-up
 - MF 12F superior flux coating eliminates need for separate supply of flux and truly eases maintenance welding work
-

OUTSTANDING PROPERTIES:

- MF 12F Provides high elongation -with outstanding shear strength and tensile strength
 - MF 12F Has a super low melting point -melts at 1230°F(660°C) and flows into tight joints in some cases at 1400°F (760°C)
 - MF 12F Gives quick freezing for all-position joining
 - MF 12F Resists corrosion and lasts longer
-

APPLICATIONS

MF 12F provides outstanding versatility as it bonds to practically all metals

- Inconel ● Monel ● Copper ● Brass ● Steel ● Stainless Steel
- Special affinity to Tungsten Carbide and Tool steel

MF 12F is ideal for clean environment applications, including food and beverage processing, kitchens, restaurants, hospitals, institutions and other places where toxic alloys are unsuitable

MF - 12F Non-Toxic Flux Coated Silver Alloy for Maintenance



MF 12F

- **MF12F** is an active flux coated brazing alloy with 56% silver content
 - **MF 12F** No odors from rubberized compounds yet the flux coating is totally flexible and non-fragile
-

MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	71,000 psi (490 N/mm ²)
Yield Strength	60,000 psi (415 N/mm ²)
Elongation	25%
Conductivity	14.3
Density	9.59 gm/cm ³
Hardness	Brinell 130

OXYACETYLENE TORCH: Slightly Carburizing

TEMPERATURE RANGES:

Working Temperature:	1210°F (655°C)
Melting Range:	1140°F (620°C) Solidus
	1200°F (650°C) Liquidus

WELDING TECHNIQUES:

After cleaning metal, preheat generally to 350°F (200°C) then heat the joint area to 800°F (420°C). Melt off some flux and allow it to flow throughout the joint. Then add alloy.

**MF - 12F Non-Toxic Flux Coated Silver
Alloy for Maintenance**

