

HABCO BA 285

HIGH STRENGTH BARE OR FLUX COATED PREMIUM TORCH BRAZING ALLOY FOR ALL STEELS

FEATURES

HABCO BA 285 is a thin flowing, high strength brazing alloy for joining of all ferrous and non-ferrous metals (except white metals). It is often used a **substitute for expensive silver alloys**. The extruded flux coating will resist moisture and chipping. **CADMIUM FREE** for repair of FOOD EQUIPMENT.

APPLICATIONS

For joining of dissimilar steels such as high nickel and copper-nickel alloys, tool Steel and cast iron. Also used for extending or repairing broken drill bits; **attaching carbides to steel shanks**. Used for joining copper and copper alloy steels.

INSTRUCTIONS

For maximum strength: Clean or grind mating edges smooth and bright. Joint fit-up should be .003" to .005". Use **HABCO FX 810** flux in deeper joints to provide better flow-through. Adjust torch to neutral flame and apply heat to work surface, keeping torch in motion along the area to be brazed. A small amount of flux can be melted from the rod on to the work surface to indicate temperature. The flux will start to liquify as base metal begins to show a slight red coloration. Continue to apply heat and alloy as needed, using the heat of the flame to draw the alloy through the joint or along the work surface. Do not melt base metal.

Tensile Strength: up to 120,000 Psi (84 kg/mm²)

Bonding Temperature: 1400°F - 1650°F (760°C - 899°C)

Diameters:

(in)	1/16	3/32	1/8
(mm)	2.0	2.5	3.25