



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 22F – High strength , easy flowing, cadmium free flux coated 56% silver solder

FEATURES & APPLICATIONS

For colour matching stainless steel and for low temperature high strength joints in the food, medical and pharmaceutical industries.

Super active flux coated cadmium free silver brazing alloy with 56% silver content

- Rare flux coated silver available in 3/64" (1.2mm) diameter for precision work.
- Special "Fast Flow" flux coating provides twice the base metal cleansing action of conventional silver flux coatings.
- No odours from rubberized compounds yet the flux coating is totally flexible and non-fragile.
- The only flux coated silver flux strong enough to clean oxidized stainless steel.
- Available bare as 3159 for use with 5130 flux

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Colour: Pink or custom colours

Ag	Cu	Zn	Sn
56	22	17	5

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Conductivity

Density

Hardness

Maximum Value Up To

71,000 PSI (490 MPa)

60,000 PSI (415 MPa)

25%

14.3

9.59/cm³

Brinell 130

Torch Setting: Slightly carburising

PROLINE

professional welding supplies

Ph: 0800 699 353
sales@prolinewelding.com



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Temperature Ranges:

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

BRAZING INSTRUCTIONS

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.

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Rod	Joint Length/1" (25mm) of Rod
3/64 (1.2)	18" (450)	.25oz (7.1g)	17" (431mm)
1/16 (1.6)	18" (450)	.33oz (9.2g)	24" (600mm)
3/32 (2.5)	18" (450)	.65oz (18g)	44" (1100mm)

APPROXIMATE ROD PACKAGING & DIMENSIONS

Diameter (mm)	3/64 (1.2)	1.16 (1.6)	3/32 (2.5)
Length (mm)	18" (450)	18" (450)	18" (450)
Rods/lb	55	32	16
Rods/kg	121	70	35
Feet/lb	82.5	48	24
Cm/kg	5445	3150	1575