



EAGLE 500 ST

Cadmium Free Strip Silver Solder

APPLICATIONS

Excellent color match on stainless steel. Used to join ferrous and non-ferrous metals when higher strengths are required than normally found with conventional solders. For use in the dairy and food industry, oxygen lines, electrical connections and general repair.

PROCEDURE

Clean the oxides off the parent metal. Use **Eagle 96** to flux the joint area. Place strip silver in the area to be soldered. Using a slightly carburizing flame, heat the joint area to 800 °F (420 °C) until the silver starts to flow. Allow work piece to cool before removing the flux residue

GENERAL CHARACTERISTICS

The **Eagle 500 ST** is a low temperature, cadmium free silver brazing strip that has excellent colour match on stainless steel.

TECHNICAL DATA

Tensile Strength: Approx. 50,000 psi
Yield Strength: Approx. 60,000 psi
Elongation: Approx. 25%
Working Temp: 1200° F / 655° C
Melting Range: 1140° F / 620° C

WELDING PARAMETERS

Slightly Carburizing Flame
Sizes Available: 1" x 0.10 mm



≡ HIGH QUALITY WELDING PRODUCTS ≡

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