



Hany One Brazing Tips

The parts that are to be brazed should be clean and free of dirt, oil, rust and oxide.

When brazing, you generally want to heat the components to be joined as equally as possible so the entire assembly uniformly comes up to temperature. Keep the torch moving and do not heat the joint (or the brazing alloy) directly. If brazing a small assembly, you may heat the entire assembly: if your components are large, apply heat to a broad area around the joint.



When the parts are up to temperature (typically a dull red color), touch the Handy One flux cored wire to the joint area. The flux and alloy will melt and be drawn by capillary attraction down into the joint. The minimal amount of flux in the Handy One cored wire reduces flux inclusions, yet provides complete alloy penetration and high strength joints.