

## Steelbond™ High-Strength Silver-Bearing Solder

- Joins all ferrous and nonferrous metals (except white metals)
- Chemically pure — does not contain any lead, zinc, cadmium or antimony
- Deposits never tarnish
- Superb color match to chrome and stainless
- Flux cored
- USDA acceptable



### SPECIFICATIONS

Joint strength.....	Up to 20,000 psi/138 MPa
Working temperature.....	430°F/221°C
Corrosion resistance.....	Very good
Flux type .....	Acid-based

### PROCEDURES

Thoroughly clean the entire weld area. Any heat source can be used to apply this alloy: torch, furnace, induction, soldering iron or gun. The final choice will be determined by the application involved. Since Steelbond is flux cored, there is no prefluxing operation; however, use of X-Ergon #381 Scavenger Flux will aid in applications involving long lap joints and on some stainless steel jobs. Using a soft, carburizing flame, indirectly heat the joint area. Touch alloy to metal to start melting off alloy and flux. Flux will instantly become active and solder will flow through the joint. Allow to cool and wash off any flux residue. Steelbond is an excellent color match to stainless steel and will assure that repairs always look perfect. Steelbond is acid cored and is not recommended for electronic work. Use X-Ergon Lectro-Plus™ solder for all electrical applications.

### APPLICATIONS

- All stainless steels
- Dairy piping
- Kitchen utensils
- HVAC shops
- Food handling equipment
- Commissary equipment
- Hospital equipment
- Repairing scored hydraulic rams

Code #	Diameter	Description
281-4-0000	1/8"	1 lb spool
281-7-0000	1/16"	1 lb spool
281-7-0012	1/16"	1/2 lb spool
281-7-2000	.031"	19 g tube
381-0-0000	Scavenger™ Flux	1 pt



<https://dod.emall.dla.mil>  
SP47W1-17-D-0009  
Available in select sizes only