

# TCS Industries Co., Inc.

## Dip Brazing Fact Sheet

### Military Specification

MIL-B-7883

MIL-STD 645

### Brazing Temperatures

**Pre-heating - Approximately  
1000°F**

**Salt Bath Immersion -Approximately  
1100°F**

### Brazeable Aluminum Alloys

| Alloy | Brazeability Rating | Heat Treatable |    |
|-------|---------------------|----------------|----|
|       |                     | Yes            | No |
| 6061  | A Good              | X              | -  |
| 6063  | A Good              | X              | -  |
| 6951  | A Good              | X              | -  |
| 1100  | A Good              | -              | X  |
| 3003  | A Good              | -              | X  |
| 7072  | A Good              | -              | X  |
| 3004  | B Fair              | -              | X  |
| 7005  | B Fair              | X              | -  |
| 5052  | C Poor              | -              | X  |
| 6151  | C Poor              | X              | -  |

***ALL ALLOYS NOT LISTED ABOVE ARE  
CONSIDERED NON-BRAZEABLE.***