

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.***