



SOBRACORE[®]

TECHNOLOGIES FOR BRAZING

**Manufacturer of
technical & tailored
products for brazing**



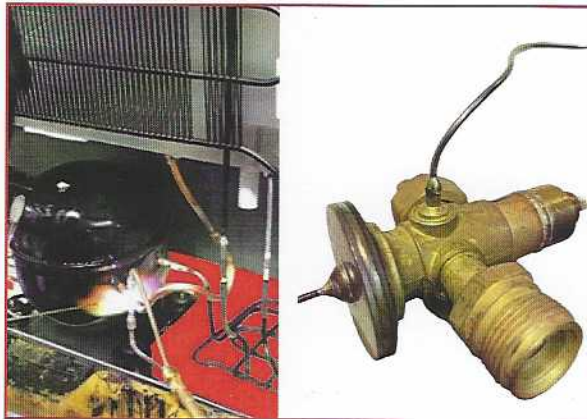
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INTRODUCTION

The brazing market is a rapidly evolving market in all industrial sectors such as the HVAC sectors, Automobiles, Constructions, carbide tools, energy production.



With the evolution of constraints: Applications, HSE, Cadences, Costs, the need to adapt products is permanent with a limited market offer. This is the reason why we specialize in the development and manufacture of zinc-based, aluminum and silver-filled brazing, the **SOBRACORE** company provides industrialists with the expertise of its members in the search for solutions for the development or improvement of the soldering process by studying and finding global solutions. Research, development and innovation are at the heart of our strategy.



SOBRACORE OFFERS

- Consulting analysis on customer processes
- Study according to product specifications
- Study for turnkey global soldering solutions
- Adjustment of products according to assembly configuration
- Follow-up of tests
- Supply of products

Since 2019, **member of the French Welding Institute** with which we have partnership agreements for technical and scientific studies of brazing products and their applications.



MEANS OF PRODUCTION



We are designer and develop our own production machines and adapt the control means from commercial systems with a permanent watch of technological evolutions.

The company **SOBRACORE** constantly adapts its means of production according to the requirements of the markets.

Controlled atmosphere manufacturing:

- 1 production site entirely dedicated to the manufacture of cored wires
- 1 production site dedicated to the production of shaped parts (rings, pins, washers, etc.)

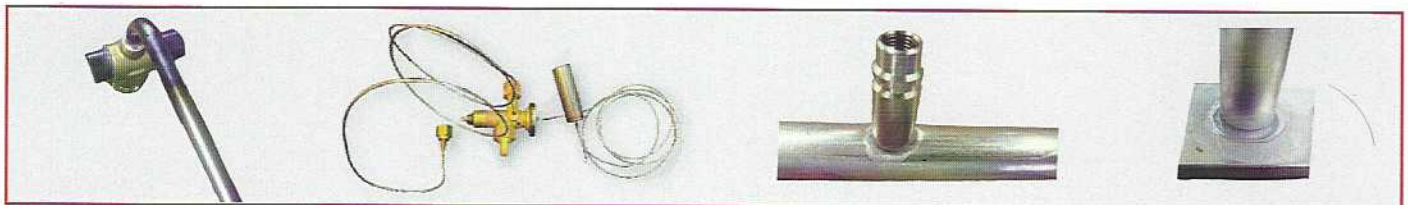
PRODUCTS, RANGES & APPLICATIONS

Flux cored wire Aluminum & Zinc Aluminum:

Product	Alloy composition %				Melting range		Standard	
	Al	Si	Zn	Other(s)	Solidus	Liquidus	AWS A5.8	ISO 17672
FCW SOBAL 1	Specific alloy				420		-	-
FCW SOBAL 2	2	-	98	-	382	407	-	-
FCW SOBAL 12	12	88	-	-	575	585	B ALSI-9	AL 112
FCW SOBAL 22	22	-	78	-	420	480	-	-
SOBAL EXPRESS	Specific alloy				390	405	-	-

PRODUCTS:

- **FCW SOBAL 1:** Aluminum-free zinc cored wire specially designed for specific applications that must resist certain types of corrosion (aluminum / aluminum or aluminum / steel / copper / brass / stainless steel)
- **FCW SOBAL 2:** 2% zinc-aluminum cored wire for universal aluminum / aluminum or aluminum / steel / copper / brass / stainless steel applications
- **FCW SOBAL 12:** Aluminum cored wire 12% silicon with a non-corrosive flux which is available in different diameters with or without internal solid wires for the adjustment of the metal / flux ratio as well as a wide range of fluxes to meet all applications
- **FCW SOBAL 22:** 22% zinc-aluminum cored wire for applications combining low melting points with high mechanical performance
- **SOBAL EXPRESS:** Universal alloy specially designed for maintenance and repair for aluminum alloys in homogeneous or heterogeneous with steel, copper, brass and stainless steel, its packaging is suitable for installers, maintenance services and also for industrial applications



Flux cored wire SILVER bases:

Product	Melting range		Alloy composition %					Standard	
	Solidus	Liquidus	Ag	Cu	Zn	Sn	Other(s)	AWS A5.8	EN ISO17672
FCW SOBAG 20T	690	810	20	44	35,8	-	Si 0,2	-	-
FCW SOBAG 25	680	760	25	40	33	2,0	-	BAG-37	AG 125
FCW SOBAG 25T	700	790	25	40	35	-	-	-	AG 225
FCW SOBAG 30T	680	765	30	38	32	-	-	BAG-20	AG 230
FCW SOBAG 34	630	730	34	36	27,5	2,5	-	-	AG 134
FCW SOBAG 38	650	720	38	32	28	2,0	-	BAG-34	AG 138
FCW SOBAG 40	650	710	40	30	28	2,0	-	BAG-28	AG 140
FCW SOBAG 45	640	680	45	27	25,5	2,5	-	BAG-36	AG 145
FCW SOBAG 45T	665	745	45	30	25	-	-	BAG-5	AG 245
FCW SOBAG 49	680	705	49	16	23	Mn 7,5	Ni 4,5	BAG-22	AG 449
FCW SOBAG 50N	660	705	50	20	28	-	Ni 2,0	BAG-24	AG 450
FCW SOBAG 56	620	655	56	22	17	5,0	-	BAG-7	AG 156

The FCW SOBAG range is developed with **carefully selected raw materials** and benefits from an integrated flow corresponding to the main application for which the alloy is intended. It is quite possible to adjust the type of feed in relation to the application.

Flux for Aluminum & Zinc Aluminum applications:

Product	Temperature range (°C)		Brazing alloys	Corrosive	Non corrosive	Standard	Powder	Paste
SOBAL-FLUX C	540	650	AlSi	✓		FL10	✓	✓
SOBAL-FLUX C 1	520	640	AlSi	✓		FL10	✓	✓
SOBAL-FLUX C 1 HD	520	640	AlSi	✓		FL10		✓
SOBAL-FLUX C 1 HDS	520	640	AlSi	✓		FL10		✓
SOBAL-FLUX N	565	572	AlSi		✓	FL20	✓	✓
SOBAL-FLUX CS	420	450	ZnAl		✓	FL20	✓	✓
SOBAL-FLUX NC	430	570	AlSi/ZnAl		✓	FL20	✓	✓

Flux for Silver Bases applications:

Product	Temperature range (°C)		Brazing alloys	Corrosive	Non corrosive	Standard	Powder	Paste
SOBAL-FLUX AG 1	500	800	Polyvalent		✓	FH20	✓	✓
SOBAL-FLUX AG 1B	500	800	Polyvalent		✓	FH20	✓	✓
SOBAL-FLUX AG 2	650	1000	Steel, cast iron		✓	FH20	✓	✓

Inseparable from metal, the fluxes developed by **SOBRACORE** are the adjustment variables essential for obtaining the desired results on brazed assemblies.

SOLID AND
CORED WIRES



RODS



RINGS



SPECIFIC
SHAPES



MACHINERY REFRIGERATION
CONSTRUCTION AIR COND
AEROSPACE INDUSTRY MAC
REFRIGERATION



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