ESTIMATING AMOUNTS OF BRAZING ALLOYS REQUIRED

1. Locate the tube diameter to be joined and the wire size to be used. Where the row and the column intersect is the approximate length (in inches) of alloy required per joint.
2. Multiply the length of the alloy needed per joint by the total number of joints.
3. To convert the total length to pounds or troy ounces, divide by the inches of alloy/lb in row A or the inches of alloy/troy oz in row B.

Tube Diameter	3/64" Wire	1/16" Wire	3/32" Wire	.050"x 1/8" Rod	Tip Size	Estimated Acetylene Use(C.F.H.)
1/4"	1 1/4"	3/4"			4	6-14
3/8"	1 1/2"	1"			4	6-14
1/2"	2"	1 1/2"	3/4"	7/8"	5	8-18
3/4"	3"	2"	1"	1 1/8"	5	8-18
1"		3"	1 1/2"	1 5/8"	6	10-20
1 1/4"		4"	2"	2 1/2"	6	10-20
1 1/2"			2 1/2"	2 3/4"	7	13-25
2"			3 3/4"	4 1/2"	8	16-32
2 1/2"			6"	7 1/2"	8	16-32
3"			10"	11 1/2"	9	20-37
3 1/2"			12"	13 3/4"	9	20-37
4"			14"	16"	10	24-42
6"			21"	23 3/4"	10	24-42
A	**1900"**	**1068"**	**475"**	**513"**	**in. of alloy/lb**	
B	**118"**	**67"**	**29"**		**in. of alloy/troy oz**	

A- Phos/copper/silver alloys. Dynaflow, Harris 15, etc.
B- Silver Brazing alloys, Safety-Silv 45, 56, etc.
The above figures are approximate and will vary depending on joint clearance, depth, and operator technique.