

TECHNICAL DATA SHEET 155

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn	860	Ag 205	L-Ag5	B-Cu55ZnAg(Si)-820/870	-

Characteristics:

BRAZARGENT 1505 is a Ternary Cd free alloy which main elements are: Copper, Zinc, Silver (5%) and Silicon. Silver and Zinc contents lowers the melting point. This viscous alloy is suitable to join most Ferrous and Non-Ferrous metals with the notable exception of Aluminium and Magnesium. Its low fluidity makes it suitable in joint configurations where the fit up is poor. It has good fillet-forming capabilities. Due to high melting alloy it is recommended for step brazing techniques. The high temperature flux coating improves the alloy flow profile.

BRAZARGENT 1505: rods are available in bare rods (to be used with ours **BORINOX** or **POLYFLUX**) or in coated rods.

Applications:

BRAZARGENT 1505 can be used for brazing ferrous metal and Steels, It can be recommended for brazing Copper and Copper based alloys, Alloy has an application in Refrigeration and Air conditioning industry, Plumbing Technology. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Si	Al	Bi	Cd	P	Pb	Max impurities
5.00	54.50	40.15	0.20	<0.001	<0.03	<0.01	<0.008	<0.025	<0.15





Typical Physical Properties:

Colour	Solidus (°C)	Liquidus (°C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver Yellow	820	870	8.40	15 %	380	-	-

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type						 OXY/ACETYLENE	 INDUCTION	 AERO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms					
Ø 1.5 to 3.0	✓	✓	X	✓	✓	Bare	✓	✓	X	✓
						Coated	✓	X	X	✓

Customised sizes other than above standard dimensions are solicited case to case basis

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TECHNICAL DATA SHEET 151

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	ISO 3677	AMS
Ag-Cu-Zn-Si	820	Ag212		B-Cu48ZnAg(Si)-800/830	-

Characteristics:

BRAZARGENT 1512Si is a Ternary Cd free alloy which main elements are: Copper, Zinc, Silver (12%) and Silicon. Silver and Zinc contents lowers the melting point. This viscous alloy is suitable to join most Ferrous and Non-Ferrous metals with the notable exception of Aluminium and Magnesium. Its low fluidity makes it suitable in joint configurations where the fit up is poor. It has good fillet-forming capabilities. Due to high melting alloy it is recommended for step brazing techniques. The recommended joint gap will be 0.075 to 0.20mm. The high temperature flux coating improves the alloy flow profile.

The rods are available in bare rods (to be used with ours **BORINOX** or **POLYFLUX**) or in coated rods.

Applications:

BRAZARGENT 1512Si can be used for brazing ferrous metal and Steels, It can be recommended for brazing Copper and Copper based alloys. Alloy has an application in Refrigeration and Air conditioning industry, Plumbing Technology. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Si	Al	Bi	Cd	P	Pb	Max impurities
12.00	48.00	39.70	0.20	<0.001	<0.03	<0.01	<0.008	<0.025	<0.15





Typical Physical Properties:

Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver	800	830	8.40	17 %	390	-	-

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø (mm) x 500	Type						 OXY/ACETYLENE	 INDUCTION	 AERO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms					
Ø 1.5 to 3.0	✓	✓	X	✓	✓	Bare	✓	✓	✓	✓
						Coated	✓	X	✓	X

Customised sizes other than above standard dimensions are solicited case to case basis

TECHNICAL DATA SHEET 165

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn	810	Ag 220	~L-Ag20	-	-

Characteristics:

BRAZARGENT 1520Si is a Ternary Cd free alloy which main elements are: Copper, Zinc, Silver (20%) and Silicon. Silver and Zinc contents lowers the melting point. This viscous alloy is suitable to join most Ferrous and Non-Ferrous metals with the notable exception of Aluminium and Magnesium. Its low fluidity makes it suitable in joint configurations where the fit up is poor. It has good fillet-forming capabilities. Due to high melting alloy it is recommended for step brazing techniques. The high temperature flux coating improves the alloy flow profile.

BRAZARGENT 1520Si: rods are available in bare rods (to be used with ours **BORINOX** or **POLYFLUX**) or in coated rods.

Applications:

BRAZARGENT 1520Si can be used for brazing ferrous metal and Steels, It can be recommended for brazing Copper and Copper based alloys, Alloy has an application in Refrigeration and Air conditioning industry, Plumbing Technology. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Si	Al	Bi	Cd	P	Pb	Max impurities
20.00	44.00	35.70	0.20	<0.001	<0.03	<0.01	<0.008	<0.025	<0.15





Typical Physical Properties:

Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver Yellow	690	810	8.40	20 %	400	23.5	7.35

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type						 OXYACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms					
Ø 1.5 to 3.0	✓	✓	X	✓	✓	Bare	✓	✓	X	✓
						Coated	✓	X	X	✓

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TECHNICAL DATA SHEET 404

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A5-8	EN 1044	EN ISO 3677	AMS
Ag-Cu-Zn	740	Ag 235Si	BAg-35	-	B-Ag35CuZn(Si)-685/755	-

Characteristics:

BRAZARGENT 1535 is a Ternary Cd free alloy which main elements are: Copper, Zinc, Silver (35%) and Silicon. Silver and Zinc contents lowers the melting point. This viscous alloy is suitable to join most Ferrous and Non-Ferrous metals with the notable exception of Aluminium and Magnesium. Its low fluidity makes it suitable in joint configurations where the fit up is poor. (Recommended joint gap will be 0.075 to 0.2 mm) It has good fillet-forming capabilities. Due to high melting alloy it is recommended for step brazing techniques. The high temperature flux coating improves the alloy flow profile.

BRAZARGENT 1535: rods are available in bare rods (to be used with ours **AGFLUX** or **HP Flux** or in coated rods.

Applications:

BRAZARGENT 1535 can be used for brazing ferrous metal and Steels, It can be recommended for brazing Copper and Copper based alloys, Alloy has an application in Refrigeration and Air conditioning industry, Plumbing Technology. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Si*	Al	Bi	Cd	P	Pb	Max impurities
35.0	31.9	33	0.10	<0.001	<0.03	<0.01	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver Yellow	685	755	9.00	22 %	420	19.75	-

Ag 235Si *: a small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brasability (no sparkling effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type						 OXY/ACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms					
Ø 1.5 to 3.0	✓	✓	X	✓	✓	Bare	✓	✓	X	✓
						Coated	✓	X	X	✓

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TECHNICAL DATA SHEET 170

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A5-8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn	730	Ag 244Si	-	L-Ag 44	B-Ag44CuZn(Si)-675/735	-

Characteristics:

BRAZARGENT 1544 is a Ternary Cd free alloy which main elements are: Copper, Zinc, Silver (44%) and Silicon. Silver and Zinc contents lowers the melting point. This viscous alloy is suitable to join most Ferrous and Non-Ferrous metals with the notable exception of Aluminium and Magnesium. Its low fluidity makes it suitable in joint configurations where the fit up is poor. (Recommended joint gap will be 0.075 to 0.2 mm) It has good fillet-forming capabilities. Due to high melting alloy it is recommended for step brazing techniques. The high temperature flux coating improves the alloy flow profile.

BRAZARGENT 1544: rods are available in bare rods (to be used with ours **AGFLUX** or **HP Flux HP**) or in coated rods.

Applications:

BRAZARGENT 1544 can be used for brazing ferrous metal and Steels, It can be recommended for brazing Copper and Copper based alloys, Alloy has an application in Refrigeration and Air conditioning industry, Plumbing Technology. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Si	Al	Bi	Cd	P	Pb	Max impurities
44.0	30.0	25.9	0.10	<0.001	<0.03	<0.01	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver Yellow	675	735	8.9	25 %	400	18.90	-

Ag 244Si *: a small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brasability (no sparking effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type						 OXY/ACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/ Spool	Preform					
Ø 1.5 to 3.0	✓	✓	X	✓	✓	Bare	✓	✓	X	✓
						Coated	✓	X	X	✓

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BRAZARGENT 3049+

(Bare rods/Coated rods)

Cadmium Free Silver (49%) Brazing Alloy

TECHNICAL DATA SHEET 350

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A5.8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn-Mn-Ni	700	Ag449Si	BAg-22	-	B-Ag49ZnCuMnNi(Si)-680-705	-

Characteristics:

BRAZARGENT 3049+ very widely used Cd free alloy which main elements are: Copper, Zinc, Mn, Ni and high Silver content at 49%. Ni & Mn improves the alloy wettability and bonding strength with Tungsten Carbides. These additions are particularly recommend when brazing alloy difficult to wet carbides and those are low cobalt and additions of Tantalum and Titanium carbides. This range has been developed to replace cadmium-bearing brazing alloys, where the use of Cd is forbidden. Lap joints are recommended. The filler metal will fill the gaps between 0.10-0.25mm and can accommodate stresses that generate during cooling due to different coefficient of thermal expansions, (better than Tin bearing alloy). Also offer good corrosion resistance and is non-toxic enabling properties. The rod is coated with our **AGFLUX** or **BORINOX Flux**.

Applications:

BRAZARGENT 3049+ is used for brazing Tools of Tungsten Carbides to Steels component. It can be used to braze Cast Iron. Operating temperature of brazed joint approx. -200°C to +200°C (without loss in strength)

Typical Chemical Compositions (%):

Ag	Cu	Zn	Mn	Ni	Al	Cd	Si	P	Pb	Max. impurities
49.00	16.00	23.00	7.50	4.40	<0.001	<0.01	0.05	<0.008	<0.025	<0.30

Typical Physical Properties:





Coating Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Customize	680	705	8.90	-	500	5.70	30.20

Ag 449 Si*: a small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brazability (no sparking effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal. This alloy needs a controlled quench (in excess of 300°C) to avoid the weakening of the brazed joint.

Standard Size, Types & Heat Source Recommendations:

Size (mm)	Type				Type				
	Bare	Coated	Coil	Preforms					
1.50 - 3.00	✓	✓	-	✓	Bare	✓	✓	✓	✓
					Coated	✓	X	✓	✓

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Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn-Ni	695	Ag450Si	BAg-24	-	B Ag50CuZnNi(Si) 660-705	4788

Characteristics:

BRAZARGENT 3050 is a low melting silver based brazing alloy with Nickel (Ni) improves wettability for Tungsten carbide and material difficult to wet, such as Molybdenum, Tantalum and Chromium. Also Improves joining strength. It improves corrosion resistance on stainless steel compared many silver braze alloys. Low flow point will minimize oxidation of stainless during brazing. Its good brazing properties makes it suitable for all heating methods.

The bare rod is coated/used with our **AGFLUX** or **HP Flux** or **BORINOX Flux**.

Applications:

BRAZARGENT 3050 can be used for brazing 300 Series Stainless Steel. This alloy aids in joining tungsten carbide inserts to Steel and Tool Steel for cutting tips. Its designed for brazing Copper, Brass, Steel, Nickel alloys. It can Typical applications are found e.g. Cutting tools, Medical, Dental and hospital applications, in Electric and Automotive industry, Plumbing. Operating temperature of brazed joint approx. -200°C to +300°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Ni	Al	Bi	Cd	Si	P	Pb	Max. impurities
50.00	20.00	28.00	1.90	<0.001	<0.001	<0.001	0.10	0.005	<0.001	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity %IACS	Electrical Resistivity (Micro-ohm-cm)
Silver	660	705	9.0	20%	540	15.10	11.80

Ag 450Si: A small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brazability (no sparking effect). This alloy can also be made with less 0.05% Silicon to be 100% Conform to NF EN ISO17672 Norm, on specific request.

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal. This alloy needs a controlled quench (in excess of 300°C) to avoid the weakening of the brazed joint.


Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type									
	Bare	Coated	TBW	Coil/Spool	Preforms					
Ø 1.5 to 3.0	√	√	√	√	√	Bare	√	√	√	√
						Coated	√	X	√	√
Ø 0.7 to 3.0						TBW	√	√	√	√

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Specifications:

Alloy	Working Temperature (°C)	DIN EN ISO 17672	ATG 	EN ISO 3677	AMS
Ag-Cu-Zn-Sn	690	~Ag140	N°1598	B-Ag40CuZnSn-650-710	-

Characteristics:

BRAZARGENT 5000 very widely used Cd free alloy which main elements are: Copper, Zinc, high Silver content at 40% and Tin. This range has been developed to replace cadmium-bearing brazing alloys, where the use of Cd is forbidden. Tin (Sn) lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate tight gaps. Its fluidity together with its very close melting range makes it suited for delicate assemblies with tight clearances. Lap joints are recommended. Also offer good corrosion resistance and is non-toxic enabling properties. The rod is to be used with our **AG PASTE**.

Applications:

BRAZARGENT 5000 to be used for brazing Gas Installations, any Steels, Copper and Copper based alloys, stainless steels, steel tools. As well as for nickel and nickel based alloys. Also can be used in food and sanitary applications, medical fluid transport. It can be used for brazing with flame or induction brazing procedures. Typical applications are found e.g. in automotive and in the Electric industry. Operating temperature of brazed joint approx. -200°C to +200°C (without loss in strength)

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si	P	Pb	Max. impurities
40.00	30.00	27.90	1.96	<0.001	<0.001	<0.001	0.04	0.005	<0.001	<0.15

Typical Physical Properties:





Alloy Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver	650	710	9.1	17%-	500	-	-

~Ag 140*: Spec. ATG B:524-3:0.05<Si<0.15% as against <0.05% Silicon in NF EN ISO17672 Norm.

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal. This alloy needs a controlled quench (in excess of 300°C) to avoid the weakening of the brazed joint.

Standard Size, Types & Heat Source Recommendations:

Size (mm)	Type				Type				
	Bare	Coated	Coil	Preforms					
1.60,2.00,(**)	✓	✓	✓	✓	Bare	✓	✓	✓	✓

(**) Dia. 1.60mm in the spool form and 2.00m cut length/ Rods as per the Specification ATG B:524.

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TECHNICAL DATA SHEET 228

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn-Sn	750	-	-	-	B-Cu47ZnAgSn(Si)-720/790	-

Characteristics:

BRAZARGENT 5018 is a Cd free alloy which main elements are: Copper, Zinc, Silver (18%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its minimum fluidity makes it suitable to penetrate tight and medium gaps. This alloy offers good performance in terms of operating, and makes it suited for assemblies with tight clearances and good joint filling capacity. This alloy offers good mechanical properties and corrosion resistance.

The rods are available in bare rods (to be used with ours **AGFLUX** or **HP Flux**) or in coated rods.

Applications:

BRAZARGENT 5018 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedures (except coated forms).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. Operating temperature of brazed joint approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
18.00	47.00	33.00	1.80	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15





Typical Physical Properties:

Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	720	790	8.40	15%	450	-	-

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type									
	Bare	Coated	TBW	Coil/Spool	Preforms					
Ø 1.5 to 3.0	✓	✓	X	✓	✓	Bare	✓	✓	✓	✓
						Coated	✓	X	✓	✓

Customised sizes other than above standard dimensions are solicited case to case basis

TECHNICAL DATA SHEET 230

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	ISO 3677	AMS
Ag-Cu-Zn-Sn	750	Ag 125Si	BAg-37	-	B-Cu40ZnAgSn(Si)-680/760	-

Characteristics:

BRAZARGENT 5025 is a Cd free alloy which main elements are: Copper, Zinc, Silver (25%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its minimum fluidity makes it suitable to penetrate tight and medium gaps. This alloy offers very good performance in terms of operating, and makes it suited for delicate assemblies with tight clearances and good joint filling capacity. This alloy offers good mechanical properties and corrosion resistance. The rods are available in bare rods to be used with ours **AGFLUX/ Paste** or in coated rods (**AGFLUX or HP Flux**).

Applications:

BRAZARGENT 5025 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedures (except coated forms).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sector. Operating temperature of brazed joint approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
25.00	40.00	33.00	1.80	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	680	760	8.50	18 %	510	19.35	9.05

Ag 125Si *: a small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brasability (no sparkling effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type						 OXYACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms					
Ø 1.5 to 3.0	✓	✓	X	✓	✓	Bare	✓	✓	X	✓
						Coated	✓	X	X	✓

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TECHNICAL DATA SHEET 235

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	ISO 3677	AMS
Ag-Cu-Zn-Sn	740	Ag 130Si	-	-	B-Cu36ZnAgSn(Si)-665/755	-

Characteristics:

BRAZARGENT 5030 is a Cd free alloy which main elements are: Copper, Zinc, Silver (30%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate tight and medium gaps. This alloy offers very good performance in terms of operating, and makes it suited for delicate assemblies with tight clearances. This alloy offers good mechanical properties and corrosion resistance.

The rods are available in bare rods to be used with ours **AGFLUX / Paste**, in coated rods (**AGFLUX or HP Flux**) and also available in **TBW** (Tubular Brazing Wire). This technology (Flux inside) offers a great efficiency in terms of application and control to metal/flux ratio (12% +/- 2).

Applications:

BRAZARGENT 5030 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedure (except coated forms).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. Operating temperature of brazed joint approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
30.00	36.00	31.50	2.30	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	665	755	8.80	18 %	500	-	-

Ag 130Si *: A small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brazability (no sparking effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type					 OXYACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms				
Ø 1.5 to 3.0	✓	✓	✓	✓	✓	Bare	✓	✓	✓
						Coated	✓	X	✓
Ø 1.6 to 3.0						TBW	✓	✓	✓

Customised sizes other than above standard dimensions are solicited case to case basis

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TECHNICAL DATA SHEET 240

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	ISO 3677	AMS
Ag-Cu-Zn-Sn	710	Ag 134Si		L-Ag34Sn	B-Cu36-AgZnSn(Si)-630/730	-

Characteristics:

BRAZARGENT 5034 is a very widely used Cd free alloy which main elements are: Copper, Zinc, Silver (34%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate tight gaps. This Brazargent 5034 alloy offers good performance in terms of operating, and makes it suited for delicate assemblies with tight and middle clearances. Offers good mechanical properties and corrosion resistance.

The rods are available in bare rods to be used with ours **AGFLUX / Paste**, in coated rods (**AGFLUX or HP Flux**) and also available in **TBW** (Tubular Brazing Wire). This technology (Flux inside) offers a great efficiency in terms of application and control to metal/flux ratio (12% +/- 2).

Applications:

BRAZARGENT 5034 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedures (except coated forms).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sector. Operating temperature of brazed joint approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
34.0	36.0	27.5	2.50	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	630	730	8.8	18 %	500	14.50	6.90

Ag134Si *: A small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brazability (no sparking effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type									
	Bare	Coated	TBW	Coil/Spool	Preforms					
Ø 1.5 to 3.0	√	√	√	√	√	Bare	√	√	√	√
						Coated	√	X	√	√
Ø 0.7 to 3.0						TBW	√	√	√	√

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TECHNICAL DATA SHEET 245

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn-Sn	690	Ag 138Si	B-Ag-34		B-Ag38CuZnSn(Si)-650/720	-

Characteristics:

BRAZARGENT 5038 is a Cd free alloy which main elements are: Copper, Zinc, Silver (38%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate tight gaps. This Brazargent 5038 alloy offers good performance in terms of operating, and makes it suited for delicate assemblies with tight clearances. Offers good mechanical properties and corrosion resistance.

The rods are available in bare rods to be used with ours **AGFLUX/ Paste**, in coated rods (**AGFLUX or HP Flux**) and also available in **TBW** (Tubular Brazing Wire). This technology (Flux inside) offers a great efficiency in terms of application and control to metal/flux ratio (12% +/- 2).

Applications:

BRAZARGENT 5038 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedures (except coated forms).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. Operating temperature of brazed joint approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
38.00	32.00	27.80	2.10	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	650	720	8.80	18 %	520	17.97	9.46

Ag 138Si *: A small amount of Silicon (~0.1%) is added to the melting in order to improve stability of the alloy and brazability (no sparking effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type					 OXYACETYLENE	 INDUCTION	 AERO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms				
Ø 1.5 to 3.0	✓	✓	✓	✓	✓	Bare	✓	✓	✓
						Coated	✓	X	X
Ø 0.7 to 3.0						TBW	✓	✓	✓

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TECHNICAL DATA SHEET 250

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn-Sn	690	Ag 140Si	BAG-28	-	B-Ag40CuZnSn(Si)-650/710	-

Characteristics:

BRAZARGENT 5040 is a very widely used Cd free alloy which main elements are: Copper, Zinc, high Silver (40%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate tight gaps. This Brazargent 5040 alloy offers very good performance in terms of operating, and makes it suited for delicate assemblies with tight clearances. Offers good mechanical properties and corrosion resistance.

The rods are available in bare rods (to be used with ours **AGFLUX/Paste**, in coated rods (**AGFLUX** or **HP Flux**) and also available in **TBW** (Tubular Brazing Wire). This technology (Flux inside) offers a great efficiency in terms of application and control to metal/flux ratio (12% +/- 2).

Applications:

BRAZARGENT 5040 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedures (except coated forms).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
40.00	30.00	28.00	1.90	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	650	710	9.1	17 %	500	18.20	9.75

Ag 140Si *: a small amount of Silicon (~0.1%) is added to the melting in order to improve stability of the alloy and brazability (no sparking effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type					 OXY/ACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms				
Ø 1.5 to 3.0	✓	✓	✓	✓	✓	Bare	✓	✓	✓
						Coated	✓	X	X
Ø 0.7 to 3.0						TBW	✓	✓	✓

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TECHNICAL DATA SHEET 255

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn-Sn	670	Ag 145Si	~BAg-36	L-Ag45Sn	B-Ag45CuZnSn(Si)-640/680	4761

Characteristics:

BRAZARGENT 5045 is a widely used Cd free alloy which main elements are: Copper, Zinc, high Silver (45%) and Tin contents. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate very tight gaps. This Brazargent 5045 alloy offers very good performance in terms of operating, and makes it suited for delicate assemblies with tight clearances. Offers good mechanical properties and corrosion resistance.

The rods are available in bare rods (to be used with ours AGFLUX/ Paste, in coated rods (**AGFLUX** or **HP Flux**) and also available in **TBW** (Tubular Brazing Wire). This technology (Flux inside) offers a great efficiency in terms of application and control to metal/flux ratio (12% +/- 2).

Applications:

BRAZARGENT 5045 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedures (except coated forms and Oven).

Applications: Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
45.00	27.00	25.50	2.40	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	640	680	9.1	14 %	500	17.90	9.60

Ag 145Si: A small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brazability (no sparking effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type					 OXY/ACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms				
Ø 1.5 to 3.0	✓	✓	✓	✓	✓	Bare	✓	✓	✓
						Coated	✓	X	X
Ø 0.7 to 3.0						TBW	✓	✓	✓

Customised sizes other than above standard dimensions are solicited case to case basis

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TECHNICAL DATA SHEET 260

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A5-8	DIN 8513	ISO 3677	AMS
Ag-Cu-Zn-Sn	660	Ag 155Si	-	-	B-Ag55CuZnSn(Si)-630/660	-

Characteristics:

BRAZARGENT 5055 is a widely used Cd free alloy which main elements are: Copper, Zinc, high Silver (55%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate very tight gaps. This Brazargent 5055 alloy offers very good performance in terms of operating, and makes it suited for delicate assemblies with tight clearances when operating temperature have to be lowers as possible. Brazargent 5055 offers good mechanical properties and corrosion resistance.

The rods are available in bare rods to be used with ours AGFLUX/ Paste or in coated rods (**AGFLUX or HP Flux**).

Applications:

BRAZARGENT 5055 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedures (except coated forms and Oven).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
55.00	21.00	22.00	1.90	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	630	660	9.2	11 %	500	18.20	9.75

~Ag 155*: A small amount of Silicon (~0.1%) is added to the melting in order to improve stability of the alloy and brazability (no sparkling effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type						 OXY/ACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms					
Ø 1.5 to 3.0	✓	✓	X	✓	✓	Bare	✓	✓	✓	✓
						Coated	✓	X	✓	X

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TECHNICAL DATA SHEET 270

Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	ISO 3677	AMS
Ag-Cu-Zn-Sn	650	Ag 156Si	BAg-7	-	B-Ag56CuZnSn(Si)-620/655	4763A

Characteristics:

BRAZARGENT 5056 is a widely used Cd free alloy which main elements are: Copper, Zinc, high Silver (56%) and Tin contents (5%). Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate very tight gaps. This Brazargent 5056 alloy offers very good performance in terms of operating, and makes it suited for delicate assemblies with tight clearances when operating temperature have to be lowers as possible. This alloy offers good mechanical properties and corrosion resistance.

The rods are available in bare rods (to be used with ours AGFLUX/ Paste, in Coated rods (**AGFLUX or HP flux**) and also available in **TBW** (Tubular Brazing Wire). This technology (Flux inside) offers a great efficiency in terms of application and control to metal/flux ratio (12% +/- 2).

Applications:

BRAZARGENT 5056 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedures (except coated forms and Oven).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
56.00	22.00	17.00	4.90	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15

Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	620	655	9.5	18%	470	20.70	8.3

Ag 156Si*: A small amount of Silicon (~0.1%) is added to the melting in order to improve stability of the alloy and brazability (no sparkling effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type					 OXY/ACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms				
Ø 1.5 to 3.0	✓	✓	✓	✓	✓	Bare	✓	✓	✓
						Coated	✓	X	X
Ø 0.7 to 3.0						TBW	✓	✓	✓

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