

### Key Facts

- 56% Silver content Flux coated
- Brazing temperature approx 650 C
- excellent capillary action where components have close fit up
- High strength bond

### Description

A self fluxing, low temperature, cadmium free brazer that can be used on ferrous and non-ferrous alloys. It has good fluidity that promotes penetration for good strength and elongation. The colour of this alloy is a good match on stainless steel. It is often used to braze stainless steel for the food service industry.

The lowest brazing temperature, best wetting, and best flow of all the cadmium-free alloys. It has a slight plastic range, which may be noticed during melting on some applications. Its low zinc content minimizes problems due to excessive heating (as in furnace brazing or due to less skilled operators).

### Classification, Approvals & Conformances

AWS A5.8 BAg-7

### Applications

Can be used for brazing any steels, copper and copper-base alloys as well as for nickel and nickel-base alloys. Applications include turbine blades, heavily galvanized tinned steel, aluminium brass tubing and stainless steel equipment in the food industry. Other applications include silverware for step brazing or enamelling for iron or nickel base alloys. It does not cause stress cracking of nickel, nickel alloys, or stainless steel as readily as the other low melting alloys.

- Ideal for brazing steel and other ferrous metals
- Refrigeration pipe joints requiring high bond
- Fire service fittings
- Food grade applications

### Typical Analysis/Composition

Ag - Silver	Zn - Zinc	Cu - Copper	Sn - Tin
5.5 - 57	15 - 19	21 - 23	4.5 - 5.5

### Typical Weld Mechanical Properties

<b>Solidus:</b>	618°C
<b>Liquidus Temp:</b>	652°C
<b>Brazing Temp:</b>	(652-760 °C)

### Packaging & Ordering Information

Size	Weight	Part Number
1.6mm	1kg	300209
1.6mm	6Stk	300209H

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.