



SILVER BEARING BRAZING ALLOYS

Fact Sheet

BRAZING COMPOSITION % WEIGHT					MELTING RANGE °C	Working Temperature °C	Standards AS 1167.1-1993 AWS As.8-81	Principal of Application	Principal materials
ALLOY	Ag	Cu	P	OTHER					
A2%	2	91.8	6.2	0	650-810	710	B2 - BCuP-6*	For use when the operating temp of the joint will not exceed 150 °C	Copper to Copper with out flux Must use flux for brass bronze red brass Not for use in media containg sulpher
A5%	5	89	6	0	650-810	710	B3 - BCuP-3*		
A15%	15	80	5	0	650-800	710	B4 - BCuP-5*		
D18%	18	74.75	7.25	0	643	650	B5		
Cadmium Free Silver Brazing Alloys for Universal Applications									
	Ag	Cu	Zn	Sn				For use where the operating temp of the joint will not exceed 200 °C	any steels copper and copper alloys nickel and nickel alloys
Ag34 Sn	34	36	27	3	630-730	710	L-Ag34Sn		
Ag38 sn	38	32	28	2	930-700	690	L-Ag38Sn		
Ag45 Sn	45	27	25	3	640-680	670	L-Ag45Sn		

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