

# TECHNICAL SHEET



## Ag45Sn

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### Product name

Ag45Sn

### Class of product

Silver based brazing alloy, cadmium-free

### Corresponding standards

DIN8513 L-Ag45Sn

EN1044 AG 104

AWS A5.8-04 BAg-36

### Nominal composition (weight %)

Ag: 45

Cu: 27

Zn: 25,5

Sn: 2,5

### Physical characteristics

Melting range (Solids – Liquids): 640 – 660 °C

Brazing temperature: 670 °C

Density: 9,2 g/cm<sup>3</sup>

Tensile Strength: 43 kg / mm<sup>2</sup>

### Range of application

Ag45Sn is a low melting, cadmium-free, silver brazing alloy with excellent flow characteristics. It can be used to join ferrous, non ferrous and dissimilar metals and alloys with close joint clearances, such as steel, copper, copper alloys, nickel, nickel alloys.

Its narrow melting range makes it usable for both manual and machine feeding into braze joint; brazing procedures range from manual to induction techniques.

When brazing in an oxidizing environment a proper flux should be used.

Typical applications are in the automotive, electric, air conditioning and refrigeration industries.

### Characteristics Make-up

Rods: Ø 0,5 > 4,0 mm Length: 500 / 1.000 mm

Flux Coated Rods: Ø 1,5 > 3,0 mm

Wires: Ø 0,25 > 3,0 mm (spooled and coiled)

Strips: Thickness: 0,1 > 1 mm Width: 1,5 > 65 mm

Rings

Performs from Wire and from Strip

Pastes & Powders

Other dimensions are available upon request

The above data are subject to change without notice by Spring.

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**SPRING WELDING ALLOYS**

Hangzhou City, Zhejiang, China

Phone – 0086-13588821060

[info@springwelding.com](mailto:info@springwelding.com) - [www.springwelding.com](http://www.springwelding.com)