

# TECHNICAL SHEET



## Ag50Ni

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### Product name

Ag50Ni

### Class of product

Silver based brazing alloy, cadmium-free

### Corresponding standards

DIN8513 ---

EN1044 ---

AWS A5.8-04 BAg-24

### Nominal composition (weight %)

Ag: 50

Cu: 20

Zn: 28

Ni: 2

### Physical characteristics

Melting range (Solids – Liquids): 660 – 715 °C

Brazing temperature: 725 °C

Density: 9,0 g/cm<sup>3</sup>

Tensile Strength: 45 kg/mm<sup>2</sup>

### Range of application:

Ag50Ni is a special application, cadmium-free, silver brazing alloy, with very good flow properties.

It can be used to join ferrous, non ferrous and dissimilar metals and alloys, such as steel, copper, copper alloys, nickel, nickel alloys.

It is particularly suited to join stainless steels and tungsten carbide cutting tips.

The nickel addition to the alloy retards joint or interface corrosion of the brazed assembly and improves bond strength.

Brazing procedures range from manual to induction techniques.

When brazing in an oxidizing environment a proper flux should be used (AG7 and/or AG8 are recommended). The main applications of this alloy are found in the joining of 300 series stainless steels in the food, medical and dental fields and in tool industry for the brazing of carbide tipped tools.

### 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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