

TECHNICAL SHEET



Ag55Sn

Product name

Ag55Sn

Class of product

Silver based brazing alloy, cadmium-free

Corresponding standards

DIN8513 L-Ag55Sn

EN1044 AG 103

AWS A5.8-04 ---

Nominal composition (weight %)

Ag: 55

Cu: 21

Zn: 22

Sn: 2

Physical characteristics

Melting range (Solids – Liquids): 630 - 660 °C

Brazing temperature: 670 °C

Density: 9,4 g/cm³

Tensile Strength: 44 kg / mm²

Range of application:

Ag55Sn 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.

It is particularly suited to join stainless steels.

Among the cadmium-free silver alloys, it is the one that exhibits the most similar brazing characteristics to the popular L-Ag40Cd cadmium-bearing alloy, being its natural substitute.

Its low zinc content minimizes the potential problems arising from zinc vaporization, due to long heating cycles or due to excessive heating.

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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