

TECHNICAL SHEET



Ag13Cd

Product name

Ag13Cd

Class of product

Silver based brazing alloy, cadmium bearing

Corresponding standards

DIN8513 ---

EN1044 ---

AWS A5.8-04 ---

Nominal composition (weight %)

Ag: 13

Cu: 44

Zn: 33

Cd: 10

Physical characteristics

Melting range (Solids – Liquids): 605 – 795 °C

Brazing temperature: 805 °C

Density: 8,7 g/cm³

Tensile Strength: 42 kg / mm²

Range of application:

Ag13Cd is a cadmium-bearing silver brazing alloy, with high melting point and wide melting range.

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

Due to its wide melting range, it can be used with good results when joint clearances are large and/or not uniform.

With this alloy particular care must be taken to keep brazing cycles as short as possible, in order to avoid possible Zinc volatilization, which will result in porosity and/or voids in the joint fillet.

When Zinc volatilization is a concern, a special version of this alloy, Ag13CdSi, with little additions of Silicon (approx. 0,2%) is recommended to be used.

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

Due to the content of Cadmium special safety precautions must be followed during brazing operations (e.g., avoid of overheating, use of mechanical ventilation, wear of respiratory masks).

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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