

# TECHNICAL SHEET



## Ag20

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### Product name

Ag20

### Class of product

Silver based brazing alloy, cadmium free

### Corresponding standards

DIN8513 L-Ag20

EN1044 AG 206

AWS A5.8-04 -----

### Nominal composition (weight %)

Ag: 20

Cu: 44

Zn: 36

Si: 0,15

### Physical characteristics

Melting range (Solids – Liquids): 690 - 810 °C

Brazing temperature: 820 °C

Density: 8,7 g/cm<sup>3</sup>

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

### Range of application:

Ag20 is a general purpose, cadmium-free, silver brazing alloy, with high melting point and very 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 very wide melting range, this alloy is mostly used for brazing large and/or not uniform joints.

Brazing procedures include manual, induction, oven techniques.

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

### 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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