

TECHNICAL SHEET

Ag49MnNi



Product name

Ag49MnNi

Class of product

Silver based brazing alloy, cadmium-free

Corresponding standards

DIN8513 L-Ag49

EN1044 AG 502

AWS A5.8-04 BAg-22

Nominal composition (weight %)

Ag: 49

Cu: 16

Zn: 23

Ni: 4,5

Mn: 7,5

Physical characteristics

Melting range (Solids – Liquids): 680 – 705 °C

Brazing temperature: 705 - 725 °C

Density: 8,9 g/cm³

Tensile Strength: 55 kg/mm²

Range of application:

Ag49MnNi is a special application, cadmium-free, silver brazing alloy, with very good flow properties and excellent tensile strength characteristics.

It can be used to join difficult-to-braze base metals such as cemented carbides, tungsten, molybdenum, etc., thanks to the addition of Nickel and Manganese which improve the wetting properties of the alloy, the tensile strength of the joint and also corrosion resistance.

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 tool industry for the brazing of carbide and/or diamond 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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