

# TECHNICAL SHEET

## Ag56Sn



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### Product name

Ag56Sn

### Class of product

Silver based brazing alloy, cadmium-free

### Corresponding standards

DIN8513 L-Ag55Sn

EN1044 AG 102

AWS A5.8-04 Bag-7

### Nominal composition (weight %)

Ag: 56

Cu: 22

Zn: 17

Sn: 5

### Physical characteristics

Melting range (Solids – Liquids): 620 - 650 °C

Brazing temperature: 660 °C

Density: 9,4 g/cm<sup>3</sup>

Tensile Strength: 48 kg / mm<sup>2</sup>

### Range of application:

Ag56Sn is a low melting, cadmium-free, silver brazing alloy with excellent flow characteristics. It exhibits the lowest brazing temperature, best wetting and best flow of all cadmium-free alloys.

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.

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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