

# TECHNICAL SHEET

## Ag60Sn/1



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### Product name

Ag60Sn/1

### Class of product

Zinc-free and Cadmium-free silver based brazing alloy

Corresponding standards

DIN8513 ---

EN1044 AG 402

AWS A5.8-04 BAg-18

### Nominal composition (weight %)

Ag: 60

Cu: 30

Sn: 10

### Physical characteristics

Melting range (Solids – Liquids): 600 - 720 °C

Brazing temperature: 730 °C

Density: 9,8 g/cm<sup>3</sup>

Range of application:

Ag60Sn/1 is a zinc-free and cadmium-free, silver brazing alloy with good flow characteristics.

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

Brazing procedures range from manual to induction techniques.

Excellent for furnace and vacuum brazing due to absence of Zinc in the alloy.

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

The alloy exhibits also good corrosion resistance to marine environment.

Typical applications are in the electric, air conditioning and refrigeration industries, and others.

### 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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