BRAZARGENT 1544

(Bare rods / Coated rods)

Cadmium Free Silver (44%) Brazing Alloy

TECHNICAL DATA SHEET 170

Specifications:

Alloy	Working Temperature (˚C)	NF EN ISO 17672 (2016-11)	AWS A5-8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn	730	Ag 244Si	-	L-Ag 44	B-Ag44CuZn(Si)-675/735	-

Characteristics:

BRAZARGENT 1544 is a Ternary Cd free alloy which main elements are: Copper, Zinc, Silver (44%) and Silicon. Silver and Zinc contents lowers the melting point. This viscous alloy is suitable to join most Ferrous and Non-Ferrous metals with the notable exception of Aluminium and Magnesium. Its low fluidity makes it suitable in joint configurations where the fit up is poor. (Recommended joint gap will be 0.075 to 0.2 mm) It has good fillet-forming capabilities. Due to high melting alloy it is recommended for step brazing techniques. The high temperature flux coating improves the alloy flow profile.

BRAZARGENT 1544: rods are available in bare rods (to be used with ours **AGFLUX or HP Flux HP)** or in coated rods.

Applications:

BRAZARGENT 1544 can be used for brazing ferrous metal and Steels, It can be recommended for brazing Copper and Copper based alloys, Alloy has an application in Refrigeration and Air conditioning industry, Plumbing Technology. Operating temperature for brazed joint is approx. -200°C to +200°C (without loss in strength).

Typical Chemical Compositions (%):

Ag	Cu	Zn	Si	Al	Bi	Cd	P	Pb	Max impurities
44.0	30.0	25.9	0.10	<0.001	<0.03	<0.01	<0.008	<0.025	<0.15

Typical Physical Properties:

Colour	Solidus (˚C)	Liquidus (˚C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver Yellow	675	735	8.9	25 %	400	18.90	-

Ag 244Si *: a small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brasability (no sparkling effect).

Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type						OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
	Bare	Coated	TBW	Coil/ Spool	Preform					
Ø 1.5 to 3.0	√	√	**X**	√	√	Bare	√	√	X	√
						Coated	√	X	X	√

Customised sizes other than above standard dimensions are solicited case to case basis