BRAZARGENT 34 GAZ

Cadmium Free Silver (34%) Brazing Alloy

Certified A.T.G. by Certigaz

TECHNICAL DATA SHEET 514

Specifications:

Alloy	Working Temperature (°C)	ATG	NF EN ISO 17672 (2016)	NF EN ISO 3677 (2016)
Ag-Cu-Zn-Sn	690	N°1614	Ag134Si	B-Cu36AgZnSn (Si)-630/730

Characteristics:

BRAZARGENT 34 GAZ is a Cd free quaternary alloy. **This alloy, in association with the flux AGFLUX is certified on checking number ATG N° 1614 with specification ATG B.524-3 (2020).** alloy which main elements are: Copper, Zinc, Silver (34%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate tight gaps. This Brazargent 34 Gaz alloy offers good performance in terms of operating, and makes it suited for delicate assemblies with tight and middle clearances. Offers good mechanical properties and corrosion resistance.
Very good technical and economical choice.

Applications:

BRAZARGENT 34 GAZ can be used for brazing any Steels, Copper and copper-based alloys, stainless steels, as well for Nickel and Nickel based alloys.

Typical applications are found e.g., in HVAC, automotive, food and sanitary, electric industry, household and healthcare sector.

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si*	P	Pb	Max impurities
34.0	36.0	27.5	2.50	<0.001	<0.03	<0.01	0.05-0.15	<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 -	630	730	8.90	20	500	14.50	6.90

Si *: following Spec ATGB.524-3 (2020) : 0.05%<Si<0.15% instead of NF EN ISO 17672 :max 0.05%

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 (mm)	Type							
	Bare	Coated	wire	Preforms	OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
1.50, 1.6 and 2.0 (**)	√	-	√	√	√	√	√	√

(**) wire of 1.5 ,1.6 or 2.0 mm in spool or coil form. Bare Rods in 2.0 mm
Preform sizes and other type are solicited case to case basis

Conformity:

Conformity of the Couple: **BRAZARGENT 34 GAZ - AGFLUX** following specification ATG B.524-3 (2020)