Selectarc BRAZING

BRAZARGENT 5000

(Bare Rods & Wire)

Cadmium Free Silver (40%) Brazing Alloy

Certified A.T.G.

TECHNICAL DATA SHEET 250B

Specifications:

Alloy	Working Temperature (˚C)	DIN EN ISO 17672	ATG	EN ISO 3677	AMS
Ag-Cu-Zn-Sn	690	~Ag140	N°1598	B-Ag40CuZnSn-650-710	-

Characteristics:

BRAZARGENT 5000 very widely used Cd free alloy which main elements are: Copper, Zinc, high Silver content at 40% and Tin. This range has been developed to replace cadmium-bearing brazing alloys, where the use of Cd is forbidden. Tin (Sn) 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. Its fluidity together with its very close melting range makes it suited for delicate assemblies with tight clearances. Lap joints are recommended. Also offer good corrosion resistance and is non-toxic enabling properties. The rod is to be used with our **AG PASTE.**

Applications:

BRAZARGENT 5000 to be used for brazing Gas Installations, any Steels, Copper and Copper based alloys, stainless steels, steel tools. As well as for nickel and nickel based alloys. Also can be used in food and sanitary applications, medical fluid transport. It can be used for brazing with flame or induction brazing procedures. Typical applications are found e.g. in automotive and in the Electric industry. Operating temperature of brazed joint approx. -200°C to +200°C (without loss in strength)

Typical Chemical Compositions (%):

Ag	Cu	Zn	Sn	Al	Bi	Cd	Si	P	Pb	Max. impurities
40.00	30.00	27.90	1.96	<0.001	<0.001	<0.001	0.04	0.005	<0.001	<0.15

Typical Physical Properties:

Alloy Colour	Solidus (˚C)	Liquidus (˚C)	Density g/cm³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohom-cm)
Silver	650	710	9.1	17%-	500	-	-

~Ag 140*: Spec. ATG B:524-3:0.05<Si<0.15% as against <0.05% Silicon in NF EN ISO17672 Norm.

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. This alloy needs a controlled quench (in excess of 300˚C) to avoid the weakening of the brazed joint.

Standard Size, Types & Heat Source Recommendations:

Size (mm)	Type				Type	OXY/ACETYLÈNE	INDUCTION	AÉRO-PROPANE	FOUR/OVEN
	Bare	Coated	Coil	Preforms					
1.60,2.00,(**)	√	√	√	√	Bare	√	√	√	√

(**) Dia. 1.60mm in the spool form and 2.00m cut length/ Rods as per the Specification ATG B:524.