BRAZARGENT 5018

(Bare rods / Coated rods)

Cadmium Free Silver (18%) Brazing Alloy

TECHNICAL DATA SHEET 228

Specifications:

Alloy	Working Temperature (˚C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn-Sn	750	-	-	-	B-Cu47ZnAgSn(Si)-720/790	-

Characteristics:

BRAZARGENT 5018 is a Cd free alloy which main elements are: Copper, Zinc, Silver (18%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its minimum fluidity makes it suitable to penetrate tight and medium gaps. This alloy offers good performance in terms of operating, and makes it suited for assemblies with tight clearances and good joint filling capacity. This alloy offers good mechanical properties and corrosion resistance.
The rods are available in bare rods (to be used with ours **AGFLUX or HP Flux)** or in coated rods.

Applications:

BRAZARGENT 5018 can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedures (except coated forms).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. 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
18.00	47.00	33.00	1.80	<0.001	<0.03	<0.01	0.10	<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	720	790	8.40	15%	450	-	-

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	Preforms					
Ø 1.5 to 3.0	√	√	X	√	√	Bare	√	√	√	√
						Coated	√	X	√	√

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