



BRAZARGENT 5025

Cadmium Free Silver Brazing Alloy

TECHNICAL DATA SHEET

Specifications:

Alloy	Working Temperature (°C)	DIN EN ISO 17672	AWS A-5.8	DIN 8513	EN ISO 3677	AMS
Ag-Cu-Zn-Sn	750	Ag125	-	L-Ag25Sn	BAg40ZnAg 680-760	-

Characteristics:

BRAZARGENT 5025 alloy is Cd free, Quaternary Silver brazing alloy. The alloy low melting silver brazing alloy with excellent flow. Its good brazing properties makes it suitable for all heating methods. Tin (Sn) lowers the melting point, increases fluidity and exhibits good wetting properties. Also offer good corrosion resistance and is non-toxic alloy. The bare rod to be used/coated with **AG Flux/ HP/Borinox Flux**

Applications:

BRAZARGENT 5025 can be used for brazing 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
25.00	40.00	33.00	1.88	<0.001	<0.001	<0.001	0.10	0.005	<0.001	<0.15





Typical Physical Properties:

Coating Colour	Solidus (°C)	Liquidus (°C)	Density g/cm ³	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohms-cm)
Customised	680	760	8.50	18	510	19.35	9.05

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. 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				
	Bare	Coated	Coil	Preforms					
1.50,2.00,2.50,3.00	√	√	√	√	Bare	√	√	X	√
					Coated	√	X	X	√

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

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