BRAZARGENT 5055

(Bare rods / Coated rods)

Cadmium Free Silver (55%) Brazing Alloy

TECHNICAL DATA SHEET 260

Specifications:

Alloy	Working Temperature (˚C)	NF EN ISO 17672 (2016-11)	AWS A5-8	DIN 8513	ISO 3677	AMS
Ag-Cu-Zn-Sn	660	Ag 155Si	-	-	B-Ag55CuZnSn(Si)-630/660	-

Characteristics:

BRAZARGENT 5055 is a widely used Cd free alloy which main elements are: Copper, Zinc, high Silver (55%) 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 very tight gaps. This Brazargent 5055 alloy offers very good performance in terms of operating, and makes it suited for delicate assemblies with tight clearances when operating temperature have to be lowers as possible. Brazargent 5055 offers good mechanical properties and corrosion resistance.
The rods are available in bare rods to be used with ours Flux (**AGFLUX or AGFLUX HP**) or in coated rods (**AGFLUX HP**).

Applications:

BRAZARGENT 5055 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 and Oven).
Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. Operating temperature for brazed joint is 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
55.00	21.00	22.00	1.90	<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	630	660	9.2	11 %	500	18.20	9.75

~Ag 155*: A small amount of Silicon (~0.1%) is added to the melting in order to improve stability of the alloy and brazability (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	Preforms					
Ø 1.5 to 3.0	√	√	**X**	√	√	Bare	√	√	√	√
						Coated	√	X	√	X

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

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