

Classifications

DIN EN ISO 3677 B-Cu44ZnAg(Si)-690/810	DIN EN ISO 17672 AG 220	DIN EN 1044 AG 206	DIN 8513 L-Ag20
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Material-No.

2.1213

Composition, typical analysis (% w/w)

Cu 44	Ag 20	Zn 36	Si 0.15
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Mechanical and physical properties

Melting range	690 - 810 °C	Tensile strength	380 - 450 N/mm ²
Working temperature	810 °C	Hardness (Brinell)	125 HB
Electrical conductivity	10,6 Sm/mm ²	Elongation (l=5d)	25 %
Specific gravity	8,7 g/cm ³		

Characteristics and typical fields of application

Silver-bearing, cadmium-free brazing alloy insensitive to overheating for gap and joint brazing of alloyed and unalloyed steel, nickel and nickel alloys, malleable cast iron, copper and copper alloys and carbides. Perfect colour match with brass. The silicon contained in the brazing filler metal can reduce the mechanical property values of welded carbon steels. For brazing joints at working temperatures of max. 300 °C.

Heat sources

Flame, induction and resistance heating, TIG-torch

Flux

F 300 – Series