fontargen brazing by voestalpine

A 314

Classifications

DIN EN ISO 3677	DIN EN ISO 17672	DIN EN 1044	DIN 8513
B-Ag55ZnCuSn(Si)-630/660	Ag 155Si	AG 103	L-Ag55Sn

Material-No.
2.5159

Composition, typical analysis (% w/w)

Cu	Ag	Sn	Zn	Si
21	55	2	22	0.1

Mechanical and physical properties

Melting range	630 - 660 °C	Tensile strength	330 - 430 N/mm²
Working temperature	650 °C	Hardness (Brinell)	110 HB
Electrical conductivity	7 Sm/mm²	Elongation (l=5d)	25 %
Specific gravity	9,4 g/cm^3		

Characteristics and typical fields of application

Silver-bearing, cadmium-free low melting 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. Brazing stainless steel provides the best possible colour match. The silicon contained in the brazing alloy can reduce the mechanical property values of welded carbon steels. Joint-brazing at working temperatures of -200 °C on austenitic and -70 °C on ferritic steels as well as up until + 200 °C. The temperature resistance of solder joints is further dependent from design (gap geometry) and the base materials to be soldered and possibly demonstrate, through an examination process.

Heat sources

Flame, induction and resistance heating, TIG-torch