fontargen brazing by voestalpine

A 319

Classifications

DIN EN ISO 3677	DIN EN ISO 17672	DIN EN 1044	DIN 8513
B-Cu36AgZnSn(Si)-630/730	Ag 134Si	AG 106	L-Ag34Sn

Material-No.
2.5157

Composition, typical analysis (% w/w)

Cu	Ag	Sn	Zn	Si
36	34	2.5	27.5	0.1

Mechanical and physical properties

Melting range	630 - 730 °C	Specific gravity	9 g/cm^3
Working temperature	710 °C	Tensile strength	360 - 480 N/mm²
Electrical conductivity	14 Sm/mm²	Elongation (l=5d)	12 %

Characteristics and typical fields of application

Cadmium free brazing alloy for gap brazing of alloyed and unalloyed steel, nickel and nickel alloys, malleable cast iron, copper and copper alloys. Suitable for the copper pipe installation according to DVGW work certificate GW 2. 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