

A 320



Classifications

DIN EN ISO 3677 B-Ag45CuZnSn(Si)-640/680	DIN EN ISO 17672 Ag 145Si	DIN EN 1044 AG 104	DIN 8513 L-Ag45Sn
Material-No. 2.5158	AWS A5.8 / SFA-5.8 BAg-36		

Composition, typical analysis (% w/w)

Cu	Ag	Sn	Zn	Si
27	45	2.5	25.5	0.1

Mechanical and physical properties

Melting range	640 - 680 °C	Specific gravity	9,2 g/cm ³
Working temperature	670 °C	Tensile strength	350 - 430 N/mm ²
Electrical conductivity	13 Sm/mm ²	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. The lot is suitable for use in seawater by marine standard VG 81245, part 3 and for copper pipe installations according to DVGW worksheet 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