

FONTARGEN A 340

Silver brazing alloy, cadmium-free

Classifications

DIN EN ISO 3677 B-Ag40CuZnSn(Si)-650/710	DIN EN ISO 17672 Ag 140Si	DIN EN 1044 AG 105	DIN 8513 L-Ag40Sn
Material-No. 2.5165	AWS A5.8 / SFA-5.8 B-Ag-28		

Composition, typical analysis (% w/w)

Cu	Ag	Sn	Zn
30	40	2	28

Mechanical and physical properties

Melting range	650 - 710 °C	Tensile strength	350 - 430 N/mm ²
Working temperature	690 °C	Hardness (Brinell)	130 HB
Electrical conductivity	11 Sm/mm ²	Elongation (l=5d)	20 %
Specific gravity	9,1 g/cm ³		

Characteristics and typical fields of application

Silver alloy, cadmium free, insensitive to overheating. Gap brazing of alloyed and unalloyed steel, nickel and nickel alloys, malleable cast iron, copper and copper alloys and carbides. Seawater resistant, according to marine standard VG 82145, part 3. 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

Flux

F 300 – Series