

TECHNICAL SHEET

Ag40Sn

Product name

Ag40Sn

Class of product

Silver based brazing alloy, cadmium-free

Corresponding standards

DIN8513	L-Ag40Sn
EN1044	AG 105
AWS A5.8-04	BAG-28

Nominal composition (weight %)

Ag:	40
Cu:	30
Zn:	28
Sn:	2

Physical characteristics

Melting range (Solidus – Liquidus):	640 – 700 °C
Brazing temperature:	710 °C
Density:	9,1 g/cm ³
Tensile Strength:	44 kg / mm ²

Range of application:

Ag40Sn is a low melting, cadmium-free, silver brazing alloy with good flow characteristics. It can be used to join ferrous, non ferrous and dissimilar metals and alloys with close joint clearances, such as steel, copper, copper alloys, nickel, nickel alloys.

Brazing procedures range from manual to induction techniques.

When brazing in an oxidizing environment a proper flux should be used.

Typical applications are in the automotive, electric, air conditioning and refrigeration industries.

Characteristics Make-up:

Rods: Ø 0,5 ☉ 4,0 mm Length: 500 / 1.000 mm

Flux Coated Rods: Ø 1,5 ☉ 3,0 mm

Wires: Ø 0,25 ☉ 3,0 mm (spooled and coiled)

Strips: Thickness: 0,1 ☉ 1 mm Width: 1,5 ☉ 65 mm

Rings

Preforms from Wire and from Strip

Pastes & Powders

Other dimensions are available upon request