

TECHNICAL SHEET

Ag25Sn

Product name

Ag25Sn

Class of product

Silver based brazing alloy, cadmium-free

Corresponding standards

ISO 17672	Ag 125
EN 1044	AG 108
AWS A5.8-04	BAG-37
DIN8513	L-Ag25Sn

Nominal composition (weight %)

Ag:	25
Cu:	40
Zn:	33
Sn:	2

Physical and technical properties

Melting range (Solidus – Liquidus):	680 - 760 °C
Brazing temperature:	~ 770 °C
Density:	8,8 g/cm ³
Tensile strength (filler metal):	48 kg/mm ²
Recommended joint gap:	0,075 – 0,2 mm
Continuous service joint operating temp.:	-200 / +200 °C

Range of application

Ag25Sn is a low melting, cadmium-free, silver brazing alloy with good flow properties.

It can be used to join ferrous, non ferrous and dissimilar metals and alloys with close joint clearances, such as steel, stainless steel, copper, copper alloys, nickel, nickel alloys.

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

Brazing procedures range from flame to induction.

Tensile strength of joints brazed with Ag25Sn will generally exceed base metals strength. Joint strength is however a function of various factors, such as: type of base metals to be joined, type of joint, joint clearance, brazing procedure, etc.

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	Spoiled and coiled
Strips:	Thickness: 0,1 ⇒ 1 mm	Width: 1,3 ⇒ 80 mm
Rings		
Preforms from Wire and from Strip		
Pastes & Powders		

Other dimensions are available upon request.

NOTE:

Information contained in this data sheet are based on the knowledge available to us at the date of last document revision and are believed to be accurate. Anyway, no data contained in this data sheet may be regarded as an assurance of any property of the product. We do not assume any responsibility for results obtained or damages occurred from the use of the information contained in this data sheet. We do not assume any responsibility for any un-proper use of the product. Users should verify the suitability and completeness of information with regard to specific use the product. As end use of product is not under our direct control, it is the user's responsibility to fully comply with applicable laws and regulations in safety and hygiene.

STELLA s.r.l.

Via Marconi 26 – 21041 ALBIZZATE (VA) – ITALY

Tel. +39-0331-985787 – Fax +39-0331-985803

info@stella-welding.com - www.stella-welding.com