

TECHNICAL SHEET

Ag60Sn

Product name

Ag60Sn

Class of product

Silver based brazing alloy, cadmium-free

Corresponding standards

ISO 17672	-----
EN1044	AG 101
AWS A5.8-04	-----
DIN8513	L-Ag60Sn

Nominal composition (weight %)

Ag:	60
Cu:	23
Zn:	14
Sn:	3

Physical and technical properties

Melting range (Solidus – Liquidus):	620 - 685 °C
Brazing temperature:	695 °C
Density:	9,6 g/cm ³
Tensile Strength(filler metal):	48 kg/mm ²
Recommended joint gap:	0,05 – 0,2 mm
Continuous service joint operating temp.:	-200 / +200 °C

Range of application

Ag60Sn is a low melting, cadmium-free, silver brazing alloy with very 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.

Its low zinc content minimizes the potential problems arising from zinc vaporization, due to long heating cycles or due to excessive heating.

Brazing procedures range from manual to induction techniques.

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

Tensile strength of joints brazed with Ag60Sn 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:

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