

TECHNICAL SHEET

Ag72

Product name

Ag72

Class of product

Silver based brazing alloy, cadmium-free and zinc-free

Corresponding standards

ISO 17672	Ag 272
EN 1044	AG 401
AWS A5.8-04	BAG-8
DIN 8513	L-Ag72

Nominal composition (weight %)

Ag: 72
Cu: 28

Physical and technical properties

Melting range (Solidus – Liquidus):	780 °C (eutectic)
Brazing temperature:	780 °C
Density:	10 g/cm ³
Tensile strength (filler metal):	35 kg/mm ²
Electrical Conductivity:	46,1 m/Ω·mm ² (79,5 % IACS)
Electrical Resistivity:	2,17 μΩ·cm
Recommended joint gap:	0,05 – 0,15 mm
Continuous service joint operating temp.:	-200 / +200 °C

Range of application

Ag72 is a cadmium-free and zinc-free silver brazing alloy, with excellent flow properties, being the eutectic composition of the silver-copper binary system.

It can be used to join ferrous and non-ferrous base metals, such as steel, stainless steel, copper, brass, etc.

Thanks to its single-point melting range and absence of zinc and cadmium, the alloy is not subject to liquation problems and to vaporization of high vapor pressure elements, being therefore highly suitable for furnace brazing under a protective atmosphere without the use of flux and for brazing in vacuum.

Tensile strength of joints brazed with Ag72 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 electric industry and for controlled atmosphere brazing in oven.

Characteristics Make-up

Rods:	Ø 0,5 ⇨ 4,0 mm	Length: 500 / 1.000 mm
Wires:	Ø 0,25 ⇨ 3,0 mm	Spooled 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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