

TECHNICAL SHEET

Ag72Zn

Product name

Ag72Zn

Class of product

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

Corresponding standards

ISO 17672 -----
EN 1044 -----
AWS A5.8-04 -----
DIN 8513 -----

Nominal composition (weight %)

Ag: 72
Zn: 28

Physical and technical properties

Melting range (Solidus – Liquidus): 710 - 730 °C
Brazing temperature: ~ 740 °C
Density: 8,4 g/cm³
Recommended joint gap: 0,075 – 0,2 mm
Continuous service joint operating temp.: -200 / +200 °C

Range of application

Ag72Zn is a cadmium-free and copper-free silver brazing alloy, with good flow properties.

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

It may be used also to braze stainless steel, but, in this case, the joint could be subject to interfacial corrosion if exposed to humid environments.

Thanks to the absence of copper in the alloy, Ag72Zn is ideal for applications where copper is not a desired element and/or could be subject to corrosion effects such as in ammonia-bearing environments (all copper alloys are rapidly attacked and corroded by ammonia in moist conditions).

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 refrigeration field for the manufacturing of units that use ammonia as the refrigerating medium.

Tensile strength of joints brazed with Ag72Zn 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.

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
Rings		
Preforms from Wire		

Other dimensions are available upon request.

NOTE:

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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