

# TECHNICAL SHEET

## Ag54Ni

### Product name

Ag54Ni

### Class of product

Silver based brazing alloy, cadmium-free

### Corresponding standards

ISO 17672	Ag 454
EN 1044	----
AWS A5.8	BAG-13
DIN 8513	----

### Nominal composition (weight %)

Ag:	54
Cu:	40
Zn:	5
Ni:	1

### Physical and technical properties

Melting range (Solidus – Liquidus):	720 - 855 °C
Brazing temperature:	~ 860 °C
Density:	~ 9,6 g/cm <sup>3</sup>
Electrical Conductivity:	28,9 m/Ω·mm <sup>2</sup> (49,8 % IACS)
Electrical Resistivity:	3,46 μΩ·cm
Recommended joint gap:	0,1 – 0,25 mm
Continuous service joint operating temp.:	-200 / +200 °C

### Range of application

Ag54Ni is a special application, cadmium-free, silver brazing alloy, with high melting point.

It can be used to join ferrous, non ferrous and dissimilar metals and alloys, such as steel, copper, copper alloys, nickel, nickel alloys, and is particularly suited to join stainless steels.

The nickel addition to the alloy retards joint or interface corrosion of the brazed assembly and improves bond strength. Its broad melting range is helpful when joint clearances are not uniform.

Ag54Ni is suitable for furnace brazing due to its low zinc content, but can also be used by flame or induction brazing techniques. To avoid liquation, the alloy should be heated rapidly through its melting range.

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

Tensile strength of joints brazed with Ag54Ni 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  
Flux Coated Rods  
Wires  
Strips  
Rings  
Preforms from Wire and from Strip  
Pastes & Powders

### 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](mailto:info@stella-welding.com) - [www.stella-welding.com](http://www.stella-welding.com)