

TECHNICAL SHEET

Ag49MnNi/1 TR 111

Product name

Ag49MnNi/1 TR 111

Class of product

Three-layered strip of silver brazing alloy, cadmium free

Corresponding standards (external brazing layers)

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

Nominal composition of external brazing layers (weight %)

Ag: 49
Cu: 27,5
Zn: 20,5
Ni: 0,5
Mn: 2,5

Physical and technical properties

Melting range (Solidus – Liquidus): 670 – 690 °C
Brazing temperature: ~ 700 °C
Density: 9,0 g/cm³
Ratio: 1:1:1

Range of application

Ag49MnNi/1 TR 111 is a special variant of the popular Ag49MnNi/1 TR copper sandwiched trifoil for the brazing of carbides and of hard-metal.

It consists of three layers of the same thickness of silver alloy – copper – silver alloy.

It is suitable for the brazing of carbides, preventing cracking phenomena due to differences in thermal expansions.

Brazing procedures range from manual to induction, and to resistance techniques.

When brazing in an oxidizing environment a proper flux should be used (AG7 and/or AG8 are recommended for manual application, AG12 for automatic dispensing systems).

The main applications of this alloy are found in the tool industry for the brazing of carbide tipped tools.

Characteristics Make-up

Strips: Thickness: 0,1 ⇒ 1 mm Width: 1,3 ⇒ 80 mm
Preforms from Strip

Other dimensions are available upon request.

NOTE:

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