

# TECHNICAL SHEET

## Ag56Sn

### Product name

Ag56Sn

### Class of product

Silver based brazing alloy, cadmium-free

### Corresponding standards

ISO 17672	Ag 156
EN 1044	AG 102
AWS A5.8-04	BAG-7
DIN8513	L-Ag55Sn

### Nominal composition (weight %)

Ag:	56
Cu:	22
Zn:	17
Sn:	5

### Physical and technical properties

Melting range (Solidus – Liquidus):	620 - 655 °C
Brazing temperature:	~ 665 °C
Density:	9,4 g/cm <sup>3</sup>
Tensile strength (filler metal):	48 kg/mm <sup>2</sup>
Electrical conductivity:	~ 7,0 m/Ω·mm <sup>2</sup>
Recommended joint gap:	0,05 – 0,15 mm
Continuous service joint operating temp.:	-200 / +200 °C

### Range of application

Ag56Sn is a low melting, cadmium-free, silver brazing alloy with excellent flow properties.

It exhibits the lowest brazing temperature, best wetting and best flow of all cadmium-free alloys.

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.

Due to its low melting point it is particularly suited to braze stainless steel; however if the stainless steel joint will be exposed to water and/or moisture, it is advised to use zinc-free or nickel-bearing alloys, in order to avoid possible problems of interfacial corrosion.

Brazing procedures range from flame to induction.

Tensile strength of joints brazed with Ag56Sn 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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