

# TECHNICAL SHEET

## Ag20

### Product name

Ag20

### Class of product

Silver based brazing alloy, cadmium-free

### Corresponding standards

ISO 17672	----
EN 1044	AG 206
AWS A5.8	----
DIN 8513	L-Ag20

### Nominal composition (weight %)

Ag:	20
Cu:	44
Zn:	36
Si:	0,15

### Physical and technical properties

Melting range (Solidus – Liquidus):	690 - 810 °C
Brazing temperature:	~ 820 °C
Density:	8,7 g/cm <sup>3</sup>
Tensile Strength (filler metal):	43 kg/mm <sup>2</sup>
Recommended joint gap:	0,075 – 0,2 mm
Continuous service joint operating temp.:	-200 / +200 °C

### Range of application

Ag20 is a general purpose, cadmium-free, silver brazing alloy, with high melting point and very wide melting range.

It can be used to join ferrous, non ferrous and dissimilar metals and alloys, such as steel, copper, copper alloys.

Due to its very wide melting range this alloy is mostly used for brazing large and/or not uniform joints.

Brazing procedures range from manual to induction techniques.

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

Tensile strength of joints brazed with Ag20 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
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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