

# TECHNICAL SHEET

## Ag34Sn

### Product name

Ag34Sn

### Class of product

Silver based brazing alloy, cadmium-free

### Corresponding standards

ISO 17672	Ag 134
EN1044	AG 106
AWS A5.8-04	-----
DIN8513	L-Ag34Sn

### Nominal composition (weight %)

Ag:	34
Cu:	36
Zn:	27,5
Sn:	2,5

### Physical and technical properties

Melting range (Solidus – Liquidus):	630 - 730 °C
Brazing temperature:	740 °C
Density:	9 g/cm <sup>3</sup>
Tensile Strength(filler metal):	48 kg/mm <sup>2</sup>
Recommended joint gap:	0,075 – 0,2 mm
Continuous service joint operating temp.:	-200 / +200 °C

### Range of application

Ag34Sn is a low melting, cadmium-free, silver brazing alloy with good flow characteristics.

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.

Brazing procedures range from flame to induction techniques.

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

Tensile strength of joints brazed with Ag34Sn 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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