

TECHNICAL SHEET

Ag44

Product name

Ag44

Class of product

Silver based brazing alloy, cadmium-free

Corresponding standards

ISO 17672	Ag 244
EN 1044	AG 203
AWS A5.8-04	----
DIN8513	L-Ag44

Nominal composition (weight %)

Ag:	44
Cu:	30
Zn:	26

Physical and technical properties

Melting range (Solidus – Liquidus):	675 - 735 °C
Brazing temperature:	~ 745 °C
Density:	9,1 g/cm ³
Tensile strength (filler metal):	51 kg/mm ²
Electrical conductivity:	~ 11,2 m/Ω·mm ²
Recommended joint gap:	0,075 – 0,2 mm
Continuous service joint operating temp.:	-200 / +200 °C

Range of application

Ag44 is a low melting, cadmium-free, silver brazing alloy with very good flow properties and high mechanical strength. It can be used to join ferrous, non ferrous and dissimilar metals and alloys with close joint clearances, such as steel, stainless steel, copper, copper alloys, nickel, nickel alloys.

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

Brazing procedures range from flame to induction.

Tensile strength of joints brazed with Ag44 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 carbide and diamond tipped tools, 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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