

TECHNICAL SHEET

Ag25

Product name

Ag25

Class of product

Silver based brazing alloy, cadmium-free

Corresponding standards

ISO 17672	Ag 225
EN1044	AG 205
AWS A5.8-04	-----
DIN8513	L-Ag25

Nominal composition (weight %)

Ag:	25
Cu:	40
Zn:	35

Physical and technical properties

Melting range (Solidus – Liquidus):	700 - 790 °C
Brazing temperature:	800 °C
Density:	8,8 g/cm ³
Tensile Strength (filler metal):	45 kg/mm ²
Recommended joint gap:	0,075 – 0,2 mm
Continuous service joint operating temp.:	-200 / +200 °C

Range of application

Ag25 is a cadmium-free, silver brazing alloy with good flow characteristics.

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

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 Ag25 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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