

# TECHNICAL SHEET

## Ag5

### Product name

Ag5

### Class of product

Silver based brazing alloy, cadmium-free

### Corresponding standards

ISO 17672	Ag 205
EN 1044	AG 208
AWS A5.8-04	----
DIN8513	L-Ag5

### Nominal composition (weight %)

Ag:	5
Cu:	55
Zn:	40
Si:	0,15

### Physical and technical properties

Melting range (Solidus – Liquidus):	820 - 870 °C
Brazing temperature:	~ 880 °C
Density:	8,4 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

Ag5 is a cadmium-free, silver brazing alloy, with very high melting point.

It is usually used to join ferrous metals and steels, and may also be used to braze copper and some copper alloys.

Due to its high melting point can be successfully used for the step-brazing technique.

Brazing techniques range from flame to induction.

When brazing in an oxidizing environment a proper high-temperature flux, such as AG5 or BR1, should be used.

Tensile strength of joints brazed with Ag5 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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