

TECHNICAL SHEET

Ag74

Product name

Ag74

Class of product

Silver based brazing alloy, cadmium-free

Corresponding standards

ISO 17672 -----
EN 1044 -----
AWS A5.8-04 -----
DIN 8513 -----

Nominal composition (weight %)

Ag: 74
Cu: 18
Zn: 8

Physical and technical properties

Melting range (Solidus – Liquidus): 740- 780 °C
Brazing temperature: ~ 790 °C
Density: 9,8 g/cm³
Recommended joint gap: 0,075 – 0,2 mm
Continuous service joint operating temp.: -200 / +200 °C

Range of application

Ag74 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.

Its low zinc content minimizes the potential problems arising from zinc vaporization, due to long heating cycles or due to excessive heating.

The alloy is also suitable for the step-brazing technique.

Brazing procedures range from manual to induction and oven techniques.

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

Tensile strength of joints brazed with Ag74 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 sectors of silverware, jewellery, metallic fashion articles, 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 Spooled and coiled

Rings

Preforms from Wire and from Strip

Pastes & Powders

Other dimensions are available upon request.

NOTE:

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STELLA s.r.l.

Via Marconi 26 – 21041 ALBIZZATE (VA) – ITALY

Tel. +39-0331-985787 – Fax +39-0331-985803

info@stella-welding.com - www.stella-welding.com