

TECHNICAL SHEET

Ag49MnNi/1 TR

Product name

Ag49MnNi/1 TR

Class of product

Three-layered strip of silver brazing alloy, cadmium free

Corresponding standards (external brazing layers)

ISO 17672 -----
EN1044 -----
AWS A5.8-04 -----
DIN 8513 -----

Nominal composition of external brazing layers (weight %)

Ag: 49
Cu: 27,5
Zn: 20,5
Ni: 0,5
Mn: 2,5

Physical and technical properties

Melting range (Solidus – Liquidus): 670 – 690 °C
Brazing temperature: ~ 700 °C
Density: 9,0 g/cm³
Ratio: 1:2:1

Range of application

Ag49MnNi/1 TR is a special application, cadmium-free, silver brazing alloy with very good flow properties.

Only available as a strip, it consists of two layers of silver brazing alloy clad onto a copper core.

It is ideal for brazing carbides onto steels, especially large pieces.

The copper core of the strip absorbs and relieves the stresses caused by the difference in thermal expansion between carbide and base metal, thus helping to prevent cracking phenomena.

Brazing procedures range from manual to induction, and to resistance techniques.

When brazing in an oxidizing environment a proper flux should be used (AG7 and/or AG8 are recommended for manual application, AG12 for automatic dispensing systems).

The main applications of this alloy are found in the tool industry for the brazing of carbide tipped tools, particularly wood-working tools, and/or any tool subject to in-service impact stresses.

Characteristics Make-up

Strips: Thickness: 0,1 ⇒ 1 mm Width: 1,3 ⇒ 80 mm
Preforms from Strip

Other dimensions are available upon request.

NOTE:

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