

TECHNICAL SHEET

Ag40Ni TR

Product name

Ag40Ni TR

Class of product

Three-layered strip of silver brazing alloy, cadmium free

Corresponding standards (external brazing layers)

ISO 17672	Ag 440
EN1044	-----
AWS A5.8-04	BAG-4
DIN 8513	-----

Nominal composition of external brazing layers (weight %)

Ag:	40
Cu:	30
Zn:	28
Ni:	2

Physical and technical properties

Melting range (Solidus – Liquidus):	670 – 780 °C
Brazing temperature:	790 °C
Density:	8,9 g/cm ³
Ratio:	1:2:1

Range of application

Ag40Ni TR is a special application, cadmium-free, silver brazing alloy with 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).

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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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