

SILVER ALLOY 35

Silver Alloy 35 Technical Data

Uses

Silver Alloy 35 is a general purpose, low temperature silver base brazing filler metal used to join both ferrous and non-ferrous metals. Because of their fairly low cost, good fatigue strength and ability to make leak-tight joints where close clearances cannot be maintained, it has been widely used in the refrigeration and air-conditioning industry.

Brazing Characteristics

Silver Alloy 35 is a low temperature, economical, brazing filler metal capable of bridging gaps where tight joints fit-up cannot be maintained. Silver Alloy 35 has a tendency to liquate (separate into low and high melting constituents) when heated slowly and therefore it is preferable to use it where the heat source is sufficient to raise the part temperature rapidly through the melting range of the brazing filler metal.

Properties of Brazed Joints

The properties of a brazed joint are dependent upon numerous factors including base metal properties, joint design, metallurgical interaction between the base metal and the filler metal.

Specifications

Silver Alloy 35 conforms to: American Welding Society (AWS) A5.8/A5.8M BAg-2

Available Forms

Wire, strip, engineered preforms, specialty preforms per customer specification, powder and paste.

**** Contains cadmium – poisonous fumes may be formed when heated.**

Do not breathe fumes. Use only with adequate ventilation such as fume collectors, exhaust ventilators, or air supplied respirators. See American National Standard Z49.1. If chest pain, cough or fever develops after use, call a physician immediately! Keep children away when using!

The Prince & Izant Company recommends using cadmium-free alloys for brazing applications. If you are presently using cadmium bearing alloy and need assistance in identifying a suitable cadmium free substitute, please contact your Prince & Izant Company sales representative.

Compare With

AMS: 4768

AWS: BAg-2

Lucas: Easy-Flo 35

PI: Silver Alloy 35

UNS: P07350

Specifications

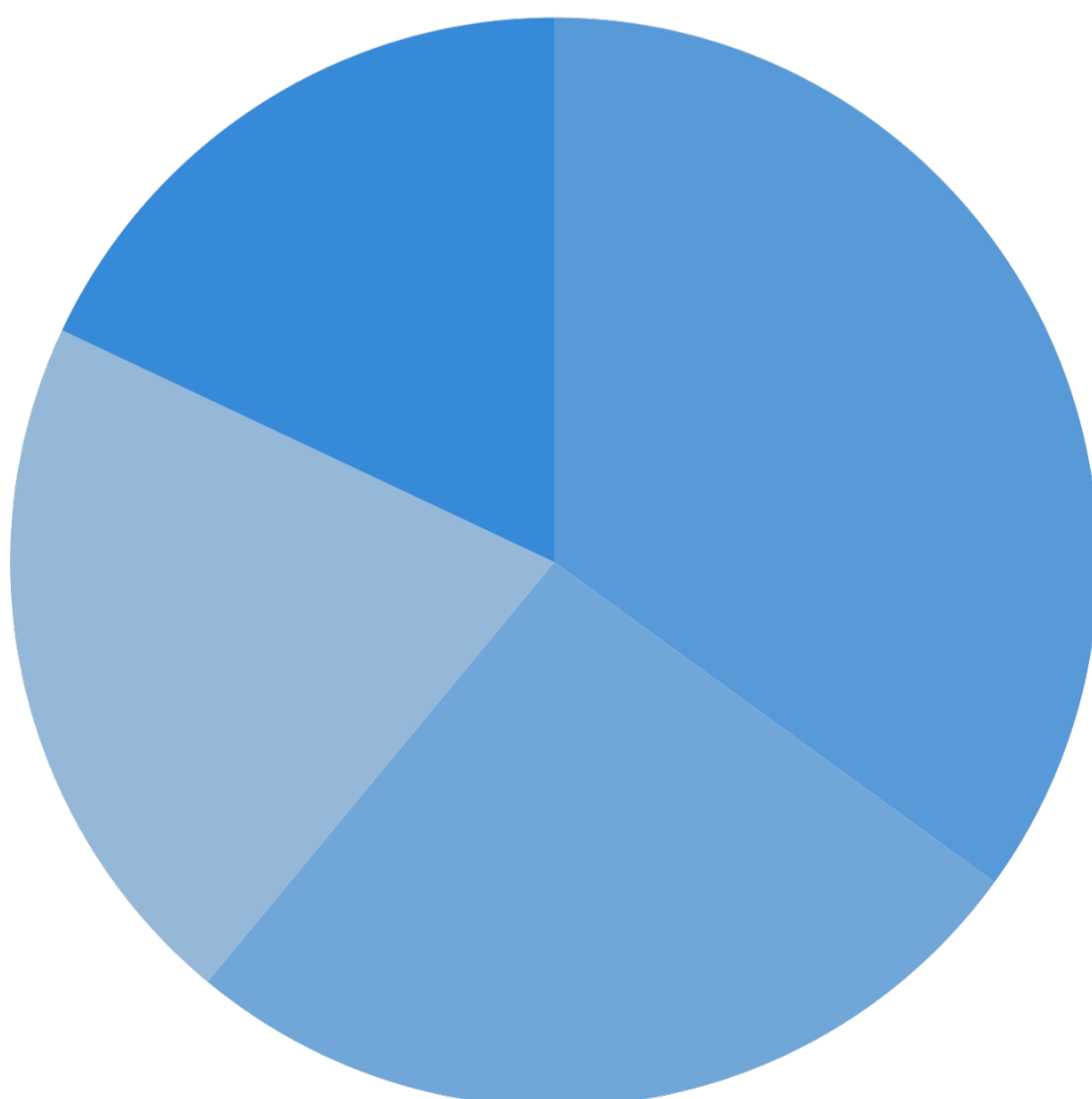
Brazing Temperature Range High: 1395 F / 757 C

Brazing Temperature Range Low: 1345 F / 729 C

Liquidus: 1295 F / 702 C

Solidus: 1125 F / 607 C

Composition



Ag: 35%

Cu: 26%

Zn: 21%

Cd: 18%