

Silver Braze 25Sn2 Tehcnical Data

Uses

The principal uses of Silver Braze 25Sn2 filler metal are for joining copper, brass, nickel-silver, bronze, steel and stainless steel.

Brazing Characteristics

Silver Braze 25Sn2 is a cadmium-free, low silver, intermediate temperature brazing filler metal. The long melting range of this filler metal is useful when wide gap joints are being brazed. Product shows good wicking. Flux is recommended for use with this filler metal. The optimal brazing range for Silver Braze 25Sn2 is 1435-1600F (780-870C)

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. Silver Braze 25Sn2 butt joints have been brazed and tested for tensile strength at room temperature, on the below metals and exhibited the following results:

| | Tensile Strength (lbs/in2) |
|---------------------|----------------------------|
| 1020 Carbon Steel | 73,400 |
| 1095 Carbon Steel | 62,500 |
| 304 Stainless Steel | 60,500 |

Specifications

Silver Braze 25Sn2 conforms to American Welding Society (AWS) A5.8/A5.8M BAg-37

Available Forms

Silver Braze 25Sn2 is available in wire, strip, engineered preforms, specialty preforms per customer specification, powder and paste.

Notes

Silver Braze 25 Sn2 is typically used for joints not requiring high impact strength nor ductility. This brazing alloy is a good alternative to cadmium-containing brazes.

Compare With

AWS: BAg-37

EN: AG 108

Lucas: Silvaloy 255

PI: Silver Braze 25Sn2

UNS: P07523

Specifications

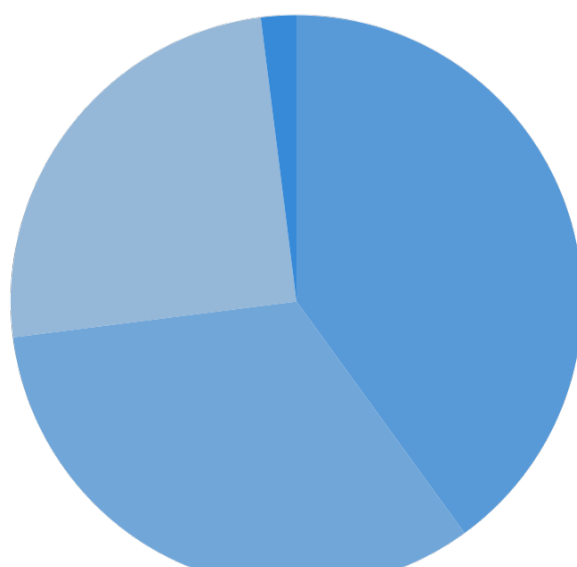
Brazing Temperature Range High: 1535 F / 835 C

Brazing Temperature Range Low: 1485 F / 807 C

Liquidus: 1435 F / 779 C

Solidus: 1270 F / 688 C

Composition



Cu: 40%

Zn: 33%

Ag: 25%

Sn: 2%