

Silver Braze 25 Technical Data

Uses

Silver Braze 25 is recommended for brazing joining tungsten carbide to steel and stainless steel.

Brazing Characteristics

Silver Braze 25 is a low silver, cadmium-free brazing filler metal, which exhibits excellent flow and wetting characteristics on tungsten carbide, steel and stainless steel. The effective melting range of 1400F (750C) - 1475F (800C) makes this material free flowing and most effective with narrow gap joints.

Properties of Brazed Joints

The properties of a brazed joint are dependent upon numerous factors. These factors include base metal properties, joint design and metallurgical interaction between the base metal and the filler metal. Silver Braze 25 lap joints, in the listed metals below, have been tested at room temperature and exhibited the following results:

	Shear Strength (lbs/in ²)
Tungsten Carbide/SAE 8740 (heat treated)	24,000 - 26,000
Tungsten Carbide/SAE 4340	28,500

Specifications

Silver Braze 25 conforms to American Welding Society (AWS) A5.8/A5.8M BAg-26

Available Forms

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

Compare With

AWS: BAg-26

Lucas: Silvaloy 252

PI: Silver Braze 25

UNS: P07251

Specifications

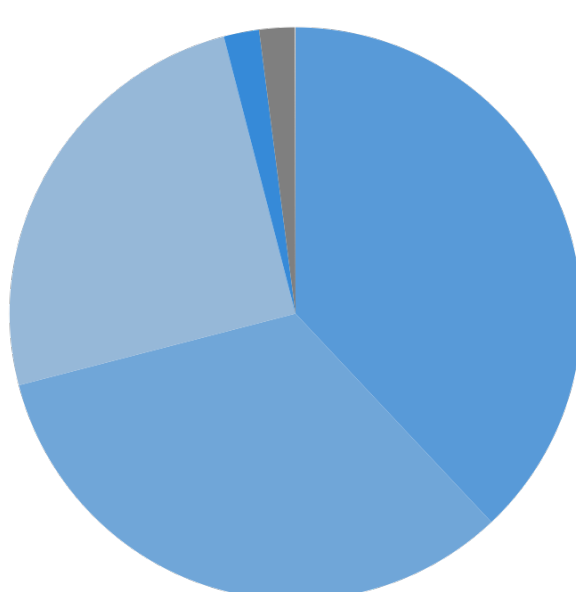
Brazing Temperature Range High: 1575 F / 857 C

Brazing Temperature Range Low: 1525 F / 829 C

Liquidus: 1475 F / 802 C

Solidus: 1305 F / 707 C

Composition



Cu: 38%

Zn: 33%

Ag: 25%

Ni: 2%

Mn: 2%