

## Prince & Izant Company

12999 Plaza Drive  
Cleveland, Ohio 44130  
T: 216-362-7000  
F: 216-362-7456  
[princeizant.com](http://princeizant.com)



## GOLD BRAZE 5025 (BVAu-7)

### TECHNICAL DATA

<b>NOMINAL COMPOSITION</b>	<b>Gold</b>	50% ± 0.5
	<b>Nickel</b>	25% ± 0.5
	<b>Cobalt</b>	0.06% max.
	<b>Palladium</b>	Balance
	<b><u>Vacuum Grade Trace Elements</u></b>	
	<b>Cadmium</b>	0.001% max.
	<b>Zinc</b>	0.001% max.
	<b>Phosphorus</b>	0.002% max.
	<b>Lead</b>	0.002% max.
	<b>Carbon</b>	0.005% max.
	<b>Other volatile elements each*</b>	0.002% max.
	<b>Volatile elements total</b>	0.010% max.
<b>Total non-volatile elements (Grade 1)</b>	0.01% max.	
<b>Total non-volatile elements (Grade 2)</b>	0.05% max.	

\*Elements with a vapor pressure higher than  $10^{-7}$  torr at 932°F (such as Mg, Sb, K, Li, Ti, S, Cs, Rb, Se, Te, Sr, and Ca) are limited to 0.001% each for Grade 1 and 0.002% for Grade 2.

<b>PHYSICAL PROPERTIES</b>	<b>Color</b>	Nickel Gray
	<b>Solidus</b>	2015°F (1101°C)
	<b>Liquidus</b>	2050°F (1121°C)
	<b>Recommended Brazing Temperature</b>	2100-2150°F (1148-1176°C)
	<b>Density (Troy oz/in<sup>3</sup>)</b>	6.92
	<b>Yield Strength (MPa)</b>	723
	<b>Tensile Strength (MPa)</b>	840
	<b>Thermal Conductivity (W/m•K)</b>	20
	<b>CTE (x10<sup>-6</sup>/°C)</b>	16
	<b>Electrical Resistivity (x10<sup>-9</sup>ohm•m)</b>	376
	<b>Electrical Conductivity (x10<sup>6</sup>/(ohm•m))</b>	2.7
	<b>Hardness (KHN)</b>	327
<b>Elongation (%)</b>	24	

**USES** Gold Braze 5025 can be used on any of the common ferrous, non-ferrous, and super alloys. In aerospace industry, Gold Braze 5025 can be used in brazing of fuel line assemblies and aero-engine components. Gold Braze 5025 can be used as the highest melting BAu alloy for step brazing in conjunction with AMS 4786 & AMS 4787.

**BRAZING  
CHARACTERISTICS**

Gold Braze 5025 wets a wide range of high temperature iron & nickel base alloys such as the stainless steels, A286, Inconel & Inconel X very well. It does not alloy excessively with these materials nor produce the severe intergranular penetration normally associated with the nickel based brazing alloys containing boron. Gold Braze 5025 has increased ductility compared to the other gold/nickel alloys, due to its increased level of Pd.  
Joint clearances of 0.0015” - 0.003” are normally suggested.

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**PROPERTIES OF  
BRAZED JOINTS**

The properties of a brazed joint are dependent upon numerous factors including base metal properties, joint design and brazing technique. For controlled atmosphere brazing or vacuum brazing the recommended radial joint clearance for gold base alloys fall within 0.000in – 0.002in (0.00mm-0.05mm) range.

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**SPECIFICATIONS**

Gold Braze 5025 alloy conforms to: Unified Numbering System (UNS) P00507, American Welding Society (AWS) BVAu-7, Society of Automotive Engineers (SAE) AMS 4784

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**AVAILABLE FORMS**

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

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Individuals requiring further information and Engineering Specification Documents may wish to contact the Engineering Society for Advanced Mobility, Land Sea Air and Space, The Society of Automotive Engineers <http://www.sae.org/> (SAE AMS) or The American Welding Society (AWS) <http://aws.org/>

**NOTE:**

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