

Prince & Izant Company

12999 Plaza Drive
Cleveland, Ohio 44130
T: 216-362-7000
F: 216-362-7456
princeizant.com



SILVERBRAZE 25Sn2 (BAg-37)

TECHNICAL DATA

NOMINAL COMPOSITION	Silver	25.0% ± 1.0
	Copper	40.0% ± 1.0
	Zinc	33.0% ± 2.0
	Tin	2.0% ± 0.5
	Other Elements Total	0.15% Max
PHYSICAL PROPERTIES	Color	Pale Yellow
	Solidus	1270°F (687°C)
	Liquidus	1435°F (779°C)
	Recommended Brazing Temperature	1485-1535°F (807-835°C)
	Density (Troy oz/in³)	4.62
	Specific Gravity	8.76
	Electrical Conductivity (%IACS)	19.4
Electrical Resistivity (Microhm-cm)	9.00	
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. Flux is recommended for use with this filler metal.	
	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.	
PROPERTIES OF BRAZED JOINTS	Tensile Strength	
	<ul style="list-style-type: none">• Carbon Steel 1020: 73,400 lbs/in²• Carbon Steel 1095: 62,500 lbs/in²• 304 Stainless Steel: 60,500 lbs/in²	
	Silver Braze 25Sn2 alloy conforms to: Unified Numbering System (UNS) P07253 and American Welding Society (AWS) A5.8/A5.8M BAg-37	
	Wire, strip, engineered preforms, specialty preforms per customer specification, powder and paste.	
AVAILABLE FORMS	Wire, strip, engineered preforms, specialty preforms per customer specification, powder and paste.	
SAFETY INFORMATION	The operation and maintenance of brazing equipment or facility should conform to the provisions of ANSI Z49.1, "Safety in Welding and Cutting."	

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:

DISCLAIMER

The information and recommendations contained in this publication have been provided without charge & compiled from sources believed to be reliable and to represent the best information available on the subject at the time of issue. No warranty, guarantee, or representation is made by the Prince and Izant Company, Inc. as to the absolute correctness or sufficiency of any representation contained in this and other publications; Prince and Izant Company, Inc. assumes no responsibility in connection therewith; nor can it be assumed that all acceptable safety measures are contained in this (and other publications, or that other or additional measures may not be required under particular or exceptional conditions or circumstances.