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SILVERBRAZE 35 (BAg-35)

TECHNICAL DATA

NOMINAL COMPOSITION	**Silver**	35.0% ± 1.0
	Copper	32.0% ± 1.0
	Zinc	33.0% ± 2.0
	Other Elements Total	0.15% Max
PHYSICAL PROPERTIES	**Color**	Yellow
	Solidus	1265°F (685°C)
	Liquidus	1390°F (754°C)
	Recommended Brazing Temperature	1440-1490°F (782-810°C)
	Density (Troy oz/in^3)	4.67
	Specific Gravity	8.87
	Electrical Conductivity (%IACS)	19.8
	Electrical Resistivity (Microhm-cm)	8.20

USES

Silver Braze 35 is a general purpose, intermediate temperature brazing alloy for use on copper, brass, nickel-silver, bronze, steel and other ferrous and nonferrous alloys melting above the liquidus point of the braze alloy. Typically applications for this braze filler metal include brazing of electrical components, and brass components such as brass lamps or brass band instruments. Silver Braze 35 is applicable in a variety of different applications that require high ductility and high strength joints.

BRAZING CHARACTERISTICS

Silver Braze 35 is an intermediate temperature silver brazing alloys with a fairly long melting range. This long melting range is helpful when wide gap joints are brazed and is useful in producing large joint fillets to reduce the notch effect on stressed assembles. Where the high brazing temperature and characteristics of this alloy are permissible the lower silver content affords a saving. Flux should be used with this alloy.

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. Similar to other nickel free alloys, Silver Braze 35 is not resistant to interface corrosion in brazing of stainless steel with use of flux thus, it is not a preferred alloy of choice for applications involving the brazing of stainless steel components.

SPECIFICATIONS

Silver Braze 35 alloy conforms to: Unified Numbering System (UNS) P07351 and American Welding Society (AWS) A5.8/A5.8M BAg-35

AVAILABLE FORMS

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

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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