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SILVERBRAZE 40Sn2 (BAg-28)

TECHNICAL DATA

NOMINAL COMPOSITION	Silver	40.0% ± 1.0	
	Copper	30.0% ± 1.0	
	Zinc	28.0% ± 2.0	
	Tin	2.0% ± 0.5	
	Other Elements Total	0.15% Max	
PHYSICAL PROPERTIES	Color	Pale Yellow	
	Solidus	1200°F (648°C)	
	Liquidus	1310°F (710°C)	
	Recommended Brazing Temperature	1360-1410°F (737-765°C)	
	Density (Troy oz/in³)	4.76	
	Specific Gravity	9.03	
	Electrical Conductivity (%IACS)	18.0	
Electrical Resistivity (Microhm-cm)	9.60		
USES	Silver Braze 40Sn2 is a good general purpose, cadmium-free intermediate temperature brazing filler metal for joining steels, copper, copper alloys and nickel alloys.		
BRAZING CHARACTERISTICS	Silver Braze 40Sn2 is a free-flowing, intermediate filler metal and as such is a good substitute for cadmium-bearing filler metals with similar silver contents. The materials is best suited for narrow gap situations (0.001"-0.005" radial joint clearance). Flux should be used with Silver Braze 40Sn2.		
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. The results listed below were generated from brazed butt joints which were tested under standard room temperature conditions.		
		<u>Tensile Strength (lbs/in²)</u>	<u>Elongation (% 2" gage length)</u>
	Copper	28,000-30,000	25-35
	Brass	35,000-45,000	15-30
	Low Carbon Steel	55,000-65,000	8-13
304 Stainless Steel	80,000-85,000	2-5	
SPECIFICATIONS	Silver Braze 40Sn2 alloy conforms to: Unified Numbering System (UNS) P07401 and American Welding Society (AWS) A5.8/A5.8M BAg-28		
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:

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