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SILVERBRAZE 72a (BAg-8a)

TECHNICAL DATA

NOMINAL COMPOSITION	Silver	72.0% ± 1.0
	Copper	Remaining
	Lithium	0.375% ± 0.125
	Other Elements Total	0.15% Max
PHYSICAL PROPERTIES	Color	Silver White
	Solidus	1410°F (765°C)
	Liquidus	1410°F (765°C)
	Recommended Brazing Temperature	1410-1510°F (765-821°C)
	Density (Troy oz/in³)	5.09
	Specific Gravity	9.67
	Electrical Conductivity (%IACS)	50.8
	Electrical Resistivity (Microhm-cm)	3.39
USES	Silver Braze 72a is a good general purpose, low temperature filler metal of high fluidity for fluxless furnace brazing of stainless steels when used in dry hydrogen or inert atmospheres.	
BRAZING CHARACTERISTICS	Silver Braze 72a is a lithium modified version of Silver Braze 72. The lithium content facilitates the wetting of stainless and refractory metals when used in a hydrogen or inert atmosphere of low dew point (-70F/-55C or direr). The use of endo-gas or exo-gas atmospheres, or standard fluxes, is not recommended since they react with the lithium and interfere with bonding. A minimum brazing temperature of 50F (10C) above the flow point is suggested for atmosphere furnace brazing. It is particularly adaptable to brazing thin sections of stainless steels because solution of the base metal by the filler metal is negligible.	
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. Joints brazed with Silver Braze 72a have been used for applications where operating temperatures where operating temperatures were intermittently as high as 900F (480C). When continuous elevated temperature exposure to oxidizing conditions is to be expecting (1000 hours or more), the maximum operating temperature should be reduced to 500F (260C). Joints made on heat resistant alloys with these filler metals are much more resistant to interface corrosion than flux brazed joints. Final acceptance should be based on tests made under the anticipated service conditions.	
SPECIFICATIONS	Silver Braze 72a conforms to: Unified Numbering System (UNS) P07723 and American Welding Society (AWS) A5.8/A5.8M BAg-8a	
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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