	TECHNICAL DATA SHEET	Realease	0 17.6.2019
		Nature of mod.	First issue
		Author	RQ
		Mod	CPO/ST Rev.2 del 17/06/2019

A.V.Saldature code T500
ISO 17672:2016 Filler metal ISO 17672-AG 449
EN 1044: AG 502
EN ISO 3677: B-50Ag Cu Zn(Mn)(Ni) –680/705
AWS A 5.8: BAg-22

Chemical Composition (%)					
A.V.	Ag Min. Max.	Cu Min. Max.	Zn Min. Max.	Sn Min. Max.	Other elements Min. Max.
T500	48 50	15 17	21 25		Mn Ni 7 4 8 5

NOTE Maximum impurity limits applicable to all types are (% by mass) Al 0,001, Bi 0,030, P 0,008, Pb 0,025; total of all impurities = 0,15; total of all impurities for Ag 427, Ag 449 and Ag 485 = 0,30.

Working temperature: 730°C
Melting range: 680/705°C
Specific gravity: 9,2 g/cm^3
Tensile strength: 380-470 N/mm^2
Elongation: 30%
Electrical conductivity: 13,0 m/Ω mm^2
Characteristics / Applications:

Silver brazing alloy with low temperature, cadmium free with improved strength characteristics. This brazing filler metal is particulary used in the brazing of tungsten carbide tools.

Heat sources:
Acetylene torch, air-gas torch, induction and resistance heating

Flux: D4, D26, D60, D70, D39H

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coeted Rods	Wire	Foil	Perform	Powder	Paste
x	x	x	x	x		