

	<h1>TECHNICAL DATA SHEET</h1>	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 T530
 ISO 17672:2016 -
 EN 1044: -
 EN ISO 3677: B-Ag50 Cu Cd Zn Mn(Ni)-680/705
 AWS A 5.8: -

Chemical Composition (%)					
A.V.	Ag	Cu	Zn	Mn	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
T530	49 51	26,5 28,5	19,5 21,5	2 3	NI 0,3 0,6

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: 690 °C
 Melting range: 680/705 °C
 Specific gravity: 9,0 g/cm³
 Tensile strength: 300 N/mm²
 Elongation: 35%

Characteristics / Applications:

Low melting silver based brazing alloy with excellent flow characteristics. This brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, (tungsten, molybdenum, tantalum and chromium). The reachable strength of the joint depends from the parent metals. It can be used for brazing with flame or induction brazing procedures, the common applications are found in the tool industry.

Heat sources:
 Acetylene torch, air-gas torch, induction

Flux: D4, D26, D60, D70, D39H DK Black

TECHNICAL SUPPLYING CONDITION ACCORDING WITH INTERNATIONAL STANDARD ISO 17672:2016

Availability

Rods	Coeted Rods	Wire	Foil	Perform	Powder	Paste
			X	X		