

	<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 T77S
 ISO 17672:2016 Filler metal ISO 17672-Ag 125
 EN 1044: AG 108
 EN ISO 3677: B-25 Cu Zn Ag (Sn) –680/760
 AWS A 5.8: BAg-37

Chemical Composition (%)					
A.V.	Ag	Cu	Zn	Sn	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
T77S	24 26	39 41	31 35	1,5 2,5	

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: 760 °C
 Melting range: 680/760 °C
 Specific gravity: 8,7 g/cm³
 Tensile strength: 420 N/mm²
 Elongation: 30%
 Electrical conductivity: 13,0 m/Ω mm²
 Characteristics / Applications:

Silver brazing alloy frequently used for the brazing of steel, copper, and brass. The low silver content makes it an economical brazing filler metal suitable for applications in which lower ductility is acceptable. Suitable for Cd free applications

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	Coated Rods	Wire	Foil	Perform	Powder	Paste
X	X	X	X	X	X	X