

	<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 T96S
 ISO 17672:2016 Filler metal ISO 17672-AG 145
 EN 1044: AG 104
 EN ISO 3677: B-45 Ag Cu Zn(Sn)–640/680
 AWS A 5.8: BAg-36

Chemical Composition (%)					
A.V.	Ag	Cu	Zn	Sn	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	Min. Max.
T96S	44 46	26 28	23,5 27,5	2 3	

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: 670 °C
 Melting range: 640/680 °C
 Specific gravity: 9,2 g/cm³
 Tensile strength: 350-430 N/mm²
 Elongation: 12%
 Electrical conductivity: 13,0 m/Ω mm²
 Characteristics / Applications:

Cd Free Silver brazing alloy with low temperature, suitable for the brazing of ferrous and nonferrous base metals. its lower brazing temperature makes it a useful replacement for several silver alloys with cadmium. Max suggested temperature of the join : 200 °C.

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