

	<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 T99
 ISO 17672:2016 Filler metal ISO 17672-AG 156
 EN 1044: AG 102
 EN ISO 3677: B-56 Ag Cu Zn(Sn)–620/655
 AWS A 5.8: BAg-7

Chemical Composition (%)					
A.V.	Ag	Cu	Zn	Sn	Other elements
	Min. Max.	Min. Max.	Min. Max.	Min. Max.	
T99	55 57	21 23	15 19	4,5 5,5	

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: 655 °C
 Melting range: 620/655 °C
 Specific gravity: 9,5 g/cm³
 Tensile strength: 410 N/mm²
 Elongation: 30%
 Characteristics / Applications:

Cadmium free Silver brazing alloy low melting range, with good flow and wetting proprieties. This alloy can minimize the stress-corrosion cracking of nickel or nickel based alloys at low temperature. It is often used in manufacture of food handling equipment. The white color makes it ideal to improve the color match cosmetically with light-color based metals

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