	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 T99S
ISO 17672:2016 Filler metal ISO 17672-AG 155
EN 1044: AG 103
EN ISO 3677: B-55 Ag Cu Zn(Sn)–630/660
AWS A 5.8: -

Chemical Composition (%)					
A.V.	Ag Min. Max.	Cu Min. Max.	Zn Min. Max.	Sn Min. Max.	Other elements Min. Max.
T99S	54 56	20 22	20 24	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: 650°C
Melting range: 630/660 °C
Specific gravity: 9,4 g/cm^3
Tensile strength: 330-430 N/mm^2
Elongation: 25%
Electrical conductivity: 13,0 m/Ω mm^2
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	Coeted Rods	Wire	Foil	Perform	Powder	Paste
x	x	x		x	x	x