

FONTARGEN A 340

Silver brazing alloy, cadmium-free



ISO 17672:	Ag 140
DIN EN 1044:	AG 105
DIN 8513:	L-Ag40Sn
EN ISO 3677:	B-Ag40CuZnSn-650/710

Composition, typical analysis (% w/w):

Ag	Cu	Zn	Sn	Si
40	30	28	2	0.15

Mechanical and physical properties:

Working temperature:	690 °C
Melting range:	650 - 710 °C
Specific gravity:	9.1 g/cm ³
Tensile strength:	350 - 430 N/mm ²
Elongation:	20 %
Electrical conductivity:	14 Sm/mm ²
Hardness:	130 BHN

Characteristics / Applications:

Silver alloy, cadmium free, insensitive to overheating. Gap brazing of alloyed and unalloyed steel, nickel and nickel alloys, malleable cast iron, copper and copper alloys and carbides. Seawater resistant, according to marine standard VG 82145, part 3. Silicon can reduce the mechanical properties of carbon steel. Joint-brazing at working temperatures of max. 200 °C.

Heat sources:

Acetylene torch, air-gas torch, induction and resistance heating

Flux:

F 300 - Series

Approval:

Marine Standard VG 81245, Part 3

Availability:

Bare rods	Coated rods	Wire	Foil	Preforms	Powder	Paste
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