

FONTARGEN A 347

Silver brazing alloy, cadmium-free



ISO 17672:	Ag 156
DIN EN 1044:	AG 102
AWS A 5.8:	BAG-7
DIN 8513:	L-Ag56Sn
EN ISO 3677:	B-Ag56ZnCuSn-620/655

Composition, typical analysis (% w/w):

Ag	Zn	Cu	Sn
56	17	22	5

Mechanical and physical properties:

Working temperature:	650 °C
Melting range:	620 - 655 °C
Specific gravity:	9.5 g/cm ³
Tensile strength:	350 - 430 N/mm ²
Elongation:	25 %
Electrical conductivity:	7 Sm/mm ²

Characteristics / Applications:

Silver-bearing, cadmium-free low melting brazing alloy, insensitive to overheating for gap and joint brazing of alloyed and unalloyed steel, nickel, nickel alloys and malleable iron as well as the corresponding metals amongst each other. Brazing stainless steel provides the best possible colour match. The absence of cadmium makes it especially suitable for joints destined to come in contact with food. For applications with service temperatures until 200°C suitable.

Heat sources:

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

Flux:

F 300 - Series

Availability:

Bare rods	Coated rods	Wire	Foil	Preforms	Powder	Paste
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