

## TECHNICAL DATA SHEET 610

### Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672 (2016-11)	AWS A-5.8	DIN 8513	ISO 3677	AMS
Ag-Cu-Zn	755	Ag 230Si	BAG-20	-	B-Cu36ZnAg(Si)-680/765	-

### Characteristics:

**BRAZARGENT 1530** is a Cd free alloy which main elements are: Copper, Zinc, Silver (30%) and Tin. Silver and Tin contents lowers the melting point, increases fluidity and exhibits good wetting properties. Its excellent fluidity makes it suitable in closely fitting joints as able to penetrate tight and medium gaps. This alloy offers very good performance in terms of operating, and makes it suited for delicate assemblies with tight clearances. This alloy offers good mechanical properties and corrosion resistance.

The rods are available in bare rods to be used with ours **AGFLUX / Paste**, in coated rods (**AGFLUX or HP Flux**) and also available in **TBW** (Tubular Brazing Wire). This technology (Flux inside) offers a great efficiency in terms of application and control to metal/flux ratio (12% +/- 2).

### Applications:

**BRAZARGENT 1530** can be used for brazing any Steels, Copper and copper based alloys, stainless steels, as well for Nickel and Nickel based alloys. Can be used for brazing with flame or induction brazing procedure (except coated forms).

Typical applications are found e.g. in HVAC, automotive, food and sanitary, electric industry, household and healthcare sectors. Operating temperature of brazed joint approx. -200°C to +200°C (without loss in strength).

### Typical Chemical Compositions (%):

Ag	Cu	Zn	Al	Bi	Cd	Si*	P	Pb	Max impurities
30.00	38.00	32.00	<0.001	<0.03	<0.01	0.10	<0.008	<0.025	<0.15

### Typical Physical Properties:





Colour	Solidus (°C)	Liquidus (°C)	Density g/cm <sup>3</sup>	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Silver - Yellow	680	765	8.86	20 %	400	24.80	6.82

Ag 230Si \*: A small amount of Silicon (~0.1%) is added during the melting in order to improve stability of the alloy and brazability (no sparking effect).

### Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal.

### Standard Size, Types and Heat Source Recommendations:

Size Ø x 500 (mm)	Type					 OXYACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	TBW	Coil/Spool	Preforms				
Ø 1.5 to 3.0	√	√	√	√	√	Bare	√	√	√
						Coated	√	X	√
Ø 1.6 to 3.0						TBW	√	√	√

Customised sizes other than above standard dimensions are solicited case to case basis

**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.