SILVER BRAZING ALLOYS

SILVER BRAZING – HOW TO
SILVER BRAZING ALLOY
FLUXES

Silver brazing alloys are produced with stringent control of precise wire size and chemical composition.

To protect the health of operators, the use of cadmium-bearing filler metals should be discontinued. Cadmium oxide fume produced during brazing operations is highly toxic and a suspected carcinogen.

Safety-Silv® brazing alloys are offered IN COIL, BARE ROD, STRAIGHT LENGTHS, FLUX COATED ROD, PRE-FORM SHAPES, AND PASTE FORMS

FLUX - Use Stay-Silv® white brazing flux on applications requiring normal heat. Use Stay-Silv® black flux on heavy parts, where localized overheating may occur, and where parts are heated over a prolonged period. Stay-Silv® black flux is also suggested when brazing stainless steel and nickel alloys.

We DO NOT recommend brazing over joints previously soldered with tin/lead solders. The low melting elements in the solder may prevent proper filler metal/base metal alloying.

Pinhole leaks in joints brazed with either the phosphorus or high silver alloys can usually be repaired with Stay Brite® solder. Take care to clean the joint thoroughly before soldering.

MSDS THIS PAGE AVAILABLE

Convenient Safety-Silv® Brazing Alloy Kits

Price	Part #	Nomenclature	Description
$40.50 PER KIT	45K	SAFETY-SILV 45-KIT	1 Av. oz. Coil Wire with 1.75 oz. Brush-cap Container White Flux
$45.65 PER KIT	56K	SAFE-SILV 56-KIT	1 Av. oz. Coil Wire with 1.75 oz. Brush-cap Container White Flux

CHARACTERISTICS OF SAFETY-SILV® SILVER BRAZING ALLOYS

COMMERCIAL CAD FREE VERSIONS OF MILITARY GRADES

CAD FREE VERSION OF GRADE #VIII

THE MOST POPULAR SILVER ALLOY
45% 1/16 X 1 TROY OUNCE
COIL #4531 $15.50 EA
CALL FOR QUOTES ON OTHERS DUE TO SILVER MARKET FLUCTUATIONS

CAD FREE VERSION OF GRADE #VII

CAD FREE VERSION OF GRADE #IV

CAD FREE VERSION OF GRADE #V

Safety-Silv®	AWS A5.8 CLASS	SOLIDUS °F - °C	LIQUIDUS °F - °C	Fluidity Rating*	TYPICAL APPLICATION DATA
25	BAg37	1265-685	1430-777	5	For steel and copper alloys. Moderate ductility. For dissimilar metals, joint should be in compression on cooling.
30	BAg20	1250-677	1410-766	6	Use with ferrous and nonferrous base metals. Flow suitable for bridging gaps.
35	BAg35	1260-682	1350-732	5	Ferrous and nonferrous base metals. Moderate temperature and good ductility.
38T	BAg34	1220-660	1325-718	7	Low-temperature, free-flowing alloy with exceptional fillet-forming quality. For ferrous and nonferrous metals.
40	-	1150-621	1350-732	5	For steel, nickel, copper alloys. Suitable for wider clearance yet provides good ductility.
40Ni2	BAg4	1220-660	1435-779	4.5	For stainless steel, nickel alloys for corrosion resistance and strength. Good choice for tungsten carbide tool tipping.
40T	BAg28	1200-649	1310-710	6.5	Good flow properties. Suitable for ferrous and nonferrous base metals.
45	BAg5	1250-677	1370-743	6.5	General purpose filler for steel alloys, copper alloys. Melting range useful for wide clearances.
☺ 45T	BAg36	1195-646	1265-685	7	Good flow properties with lower brazing temperature. Designed for use on copper, brass and steel.
50	BAg6	1270-688	1425-774	5.5	Often used to braze galvanized steel but suitable for bridging gaps in other ferrous and nonferrous metals.
50N	BAg24	1220-660	1305-707	7	For stainless steel applications, to prevent crevice corrosion.
54	BAg13	1325-718	1575-857	4	For higher temperature service. Frequently used to braze aircraft parts.
☺ 56	BAg7	1145-618	1205-652	8	For ferrous and nonferrous alloys. Often used to braze stainless steel for food service.

PARTS WITH CADMIUM
1/16" Diameter x 1 T/O (Troy Ounce)

GRADE IV, #5031CD **$15.25 Per T/O**
GRADE V, #50N31CD **$15.25 Per T/O**

THIS BRAZING ALLOY IS ONLY AVAILABLE FOR MILITARY SALES

*The higher the fluidity rating, the faster the alloy flows within the melting range. ☺ Denotes acceptance by the National Safety Foundation.