

FONTARGEN A 312 F

3-layer-silver brazing foil, cadmium-free



EN ISO 3677: B-Ag49ZnCuMnNi-680/705

Composition, typical analysis (% w/w):

Ag	Zn	Ni	Mn	Cu
49	20.5	0.5	2.5	27.5

Composition refers to the different solder coats

Mechanical and physical properties:

Working temperature:	690 °C
Melting range:	680 - 705 °C
Specific gravity:	9.0 g/cm ³
Shear strength:	150 - 300 N/mm ² (depends on Co-content of metal)
Elongation:	35 %

Characteristics / Applications:

Copper foil coated with silver brazing filler metal on both sides for the joining of hard metals and carrier steel. The foil is build-up with a ratio 1:2:1. The copper which does not melt during the brazing process relieves the stress that occurs during brazing due to the difference in coefficients of expansion of the hard metal layer and the carrier steel. Compared to A 324, A 312 F has a lower manganese- and nickel content.

Heat sources:

Acetylene torch, induction and resistance heating

Flux:

F 300 - Series, particularly recommendable: F 300 HF Ultra

Availability:

Bare rods	Coated rods	Wire	Foil	Preforms	Powder	Paste
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