

FONTARGEN A 320

Silver brazing alloy, cadmium-free



| | |
|--------------|----------------------|
| ISO 17672: | Ag 145 |
| DIN EN 1044: | AG 104 |
| DIN 8513: | L-Ag45Sn |
| EN ISO 3677: | B-Ag45CuZnSn-640/680 |
| AWS A 5.8: | B-Ag-36 |

Composition, typical analysis (% w/w):

| Ag | Cu | Zn | Sn |
|----|----|------|-----|
| 45 | 27 | 25.5 | 2.5 |

Mechanical and physical properties:

| | |
|--------------------------|-----------------------------|
| Working temperature: | 670 °C |
| Melting range: | 640 - 680 °C |
| Specific gravity: | 9.2 g/cm ³ |
| Tensile strength: | 350 - 430 N/mm ² |
| Elongation: | 12 % |
| Electrical conductivity: | 13 Sm/mm ² |

Characteristics / Applications:

Cadmium free brazing alloy for gap brazing of alloyed and unalloyed steel, nickel and nickel alloys, malleable cast iron, copper and copper alloys. Approval: Marine code VG 81245, section 3. Also suitable for the copper pipe installation according to DVGW work certificate GW 2. The silicon contained in the brazing alloy can reduce the mechanical property values of welded carbon steels. 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:

DVGW work certificate GW 2

Marine code VG 81245, section 3

Availability:

| Bare rods | Coated rods | Wire | Foil | Preforms | Powder | Paste |
|-------------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|
| <input checked="" type="checkbox"/> |

13/10/JL/1