

FONTARGEN A 324

Silver brazing alloy, cadmium free



ISO 17672:	Ag 449
DIN EN 1044:	AG 502
DIN 8513:	L-Ag49
EN ISO 3677:	B-Ag49ZnCuMnNi-680/705
AWS A 5.8:	BAG-22

Composition, typical analysis (% w/w):

Ag	Zn	Cu	Mn	Ni
49	23	16	7.5	4.5

Mechanical and physical properties:

Working temperature:	690 °C
Melting range:	680 - 705 °C
Specific gravity:	8.9 g/cm ³
Shear strength:	250 - 300 N/mm ² (depends on Co-content of hard metals)
Electrical conductivity:	4 Sm/mm ²

Characteristics / Applications:

Nickel- and manganese-bearing silver brazing alloy with very good wetting properties on steel and hard metals, therefore ensuring very tough joints. Gap brazing of hard metals in combination with steel, tungsten, tantalum and molybdenum materials.

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
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>				

13/10/JL/1