

# FONTARGEN AP 308 V

## Silver-Copper-Eutectic paste for vacuum brazing



ISO 17672:	Ag 272 <sup>a</sup>
DIN EN 1044:	AG 401
DIN 8513:	L-Ag72
EN ISO 3677:	B-Ag72Cu-780
AWS A 5.8:	BAg-8

### Composition, typical analysis (% w/w):

Ag	Cu
72	28

### Mechanical and physical properties:

Working temperature:	780 °C
Melting range:	779 °C (Eutectic)
Specific gravity:	10 g/cm <sup>3</sup> (Metal content)
Electrical conductivity:	46.1 Sm/mm <sup>2</sup>

### Characteristics / Applications:

Zinc- and cadmium free alloy with good flowing properties for gap brazing in vacuum and for vacuum-sealed joints of alloyed and unalloyed steel, nickel and nickel alloys. Very good vacuum durability even at high temperatures. Also suitable for joints of copper and copper alloys. The brazing alloy is coalesced in vacuum with a minimum purity of 99.9 %.

### Heat sources:

Vacuum furnace

### Flux:

None

### Storage:

Keep sealed, under stable temperatures in dry rooms. Optimum temperature range is between 5 and 20 °C. Stir well before use.

### Shelf life:

6 months in pots; 3 months in cartridges > 175 ccm; 6 weeks in cartridges < 175 ccm.

### Availability:

On request

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

13/10/JL/1