

# FONTARGEN AP 314

## Silver brazing alloy, cadmium-free



ISO 17672:	Ag 156
DIN EN 1044:	AG 102
DIN 8513:	L-Ag55Sn
EN ISO 3677:	B-Ag56CuZnSn-620/655

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

Ag	Cu	Zn	Sn
56	22	17	5

### Mechanical and physical properties:

Working temperature:	660 °C
Melting range:	620 - 655 °C
Specific gravity:	9.4 g/cm <sup>3</sup>
Electrical conductivity:	7 Sm/mm <sup>2</sup>

### Characteristics / Applications:

Cadmium-free low melting silver brazing alloy for gap and joint brazing of alloyed and unalloyed steel, nickel and nickel alloys, malleable cast iron, copper and copper alloys and carbides. Brazing stainless steel produces the best possible colour match. The paste is suitable for brazing joints used in seawater according to marine code VG 81245, section 3. The absence of cadmium makes it especially suitable for joints destined to come in contact with food. For brazing joints with a working temperature of max. 200 °C.

### Heat sources:

Oxy-acetylene torch, induction, resistance

### Flux:

The content of our binders can be altered according to your application depending on (heat source, atmosphere, geometry of the brazing assembly etc.). We can offer flux free and flux containing binder systems. The powder characteristics can be adapted (Metal content of the paste, grain size, geometry). Our application technicians will be pleased to assist you in choosing the appropriate product.

### Approval:

Marine code VG 81245, section 3

### 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"/>

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