

FONTARGEN AP 317

Silver brazing alloy, cadmium free



ISO 17672:	Ag 160
DIN EN 1044:	AG 402
EN ISO 3677:	B-Ag60CuSn-600/730
AWS A 5.8:	BAg-18
AMS:	4773 F

Composition, typical analysis (% w/w):

Ag	Cu	Sn
60	30	10

Mechanical and physical properties:

Working temperature:	740 °C
Melting range:	600 - 730 °C
Specific gravity:	9.8 g/cm ³ (Metal content)
Electrical conductivity:	8.7 Sm/mm ²

Characteristics / Applications:

Zinc- and cadmium-free silver brazing alloy, low vacuum-resistant. For gap brazing of alloyed and unalloyed steel, nickel and nickel alloys, malleable cast iron, copper and copper alloys. Excellent in reducing atmospheres since no contamination of the furnace can occur through the evaporation of the contents of the alloy. The paste is particularly suitable for brazing at supply circuits in aircraft construction.

Heat sources:

Oxy-acetylene torch, induction, furnace, vacuum.

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.

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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