

# FONTARGEN AP 350

## Cadmiun-free silver brazing paste



ISO 17672:	Ag 450
EN ISO 3677:	B-Ag50ZnCuNi-660/705
AWS A 5.8:	BAg-24
AMS:	4788

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

Ag	Cu	Zn	Ni
50	20	28	2

### Mechanical and physical properties:

Working temperature:	670 °C
Melting range:	660 - 705 °C
Specific gravity:	9.17 g/cm <sup>3</sup> (Metal content)

### Characteristics / Applications:

Low melting cadmium free silver brazing paste with good wetting and excellent mechanical properties. Suitable for the brazing of hard metals with steel, tungsten, tantalum and molybdenum materials. The alloy is used in the tooling industry and on stainless steel food handling equipment with close joint clearance. For brazing joints operating at temperatures up to 200 °C, respectively up to 150 °C continuous operating temperature.

### 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.

### 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