

Technical data

Silver brazing filler metal

Silver-flo™ 25 – Cadmium free silver brazing filler metal

Product description

Silver-flo™ 25 is a high melting point cadmium free silver brazing filler metal. It has a high melting temperature (700 to 790°C) with a quoted melting range of 90°C. This melting range suggests medium to sluggish flow properties when molten.

The high brazing temperature of the filler metal makes it less easy to use than the high silver content alloys.

Optimum joint gaps at brazing temperature are 0.075-0.2mm

Composition: 25%Ag, 40%Cu, 35%Zn

Conforms to: EN1044 1999 AG205, ISO 17672:2010 Ag 225

Melting range: 700-790 °C

Uses for this product

Silver-flo™ 25 can be used to join most common engineering metals - copper, copper alloys including, brasses, bronzes, gun metal, nickel silver, aluminium bronze, copper nickel, steels including, mild, carbon, tool steel, stainless steels, low alloy steel. This alloy is not normally recommended for brazing tungsten carbide and PCD segments where lower melting or nickel / manganese containing silver brazing filler metals are often preferred.

Conditions for use

Silver-flo™ 25 is designed for brazing in air with the use of a flux. Generally it is necessary to use a flux with a higher working range than Easy-flo™Flux, such as Tenacity™No. 4A Flux, Tenacity™No. 5 Flux or Tenacity™No. 20 Flux. However on small components and with rapid heating cycles a general-purpose flux such as Easy-flo™Flux Powder may be acceptable.

Product availability

Rods	1mm, 1.2mm, 1.5mm dia
Wire	1mm
Foil	On request
Braze-pastes	On request
Powder	On request
Others	Rings, Preformed Shapes

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