

## Technical data

### Silver brazing filler metal

#### Silver-flo™ 252 – Cadmium free silver brazing filler metal

#### Product description

Silver-flo™ 252 is a cadmium-free silver brazing filler metal. It has a medium melting temperature (680 to 760°C) with a long melting range of 80°C. This melting range suggests that Silver-flo™ 252 will demonstrate medium to sluggish flow and good gap filling properties when molten. This makes it an ideal choice for applications where fillets are required or close tolerance joint gaps are not present.

Because of the combination of a low silver content and a medium melting temperature this filler metal can provide a cost effective alternative to filler metals with a higher level of silver. In these instances it is advised that customers evaluate fully the cost of making a brazed joint as part of the process of filler metal selection.

With a fast heating method Silver-flo™ 252 may be used below the point at which it becomes necessary to use a high temperature flux enabling easier removal of flux residues after brazing.

Optimum joint gaps at brazing temperature are 0.075-0.2mm

**Composition:** 25%Ag, 40%Cu, 33%Zn, 2%Sn

**Conforms to:** ISO 17672:2010 Ag 125, Formerly EN1044 (1999) AG108\*

**Melting range:** 680-760 °C

\*Impurity level for cadmium reduced to 0.010 (ROHS Compliant)

#### Uses for this product

Silver-flo™ 252 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.

Silver-flo™ 252 may be used for brazing steel to steel and copper to steel pipe work in the refrigeration, heat exchanger and air-conditioning industries for example.

#### Conditions for use

Silver-flo™ 252 should be used for brazing in air with the use of a flux.

Easy-flo™ Medium Temperature Grade Flux Paste, Tenacity™ No. 4A Flux, Tenacity™ No. 5 Flux or Tenacity™ No. 20 Flux may be used. On small components and / or with rapid heating cycles a specialised flux such as Easy-flo™ Medium Temperature Grade Flux Paste may give the best results.

#### Product availability

All common forms available to special order

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