

## Technical data

### Silver brazing filler metal

#### Silver-flo™ 302 – Cadmium free silver brazing filler metal

#### Product description

Silver-flo™ 302 is a cadmium free silver brazing filler metal. It has a long melting range and medium flow characteristics making it an ideal choice for applications where fillets are required or close tolerance joint gaps are not present. It is extensively used for brazing steel to steel and copper to steel pipe work in the refrigeration, heat exchanger and air-conditioning industries. Silver-flo™ 302 is popular as a flux coated rod for site or maintenance work. Optimum joint gaps at brazing temperature are 0.075-0.2mm.

**Composition:** 30%Ag, 36%Cu, 32%Zn, 2%Sn

**Conforms to:** EN1044 1999 AG107, ISO 17672:2010 Ag 130, formerly BS 1845 AG21, MSRR 9500/104

**Melting range:** 665-755 °C

#### Uses for this product

This filler metal can be used to join all the common engineering materials (excluding aluminium) – such as copper, copper alloys (including, brasses, bronzes, gun metal, nickel silvers, aluminium bronze, copper nickel) and steel (including, mild, carbon, tool steel, stainless steels and low alloy steel). It may be used for brazing tungsten carbide and PCD segments however where cracking of the carbide or wetting of the filler metal may be an issue specialised silver brazing filler metals containing nickel / manganese are often preferred.

#### Conditions for use

This filler metal is mainly used for brazing in air with a flux. In most cases Easy-flo™ Flux can be used in conjunction with Silver-flo™ 302. However, flux selection is application dependent. Please refer to JM technical department or flux product datasheets before selecting a flux.

#### Product availability

Rod	1.5mm, 2.5mm
Flux coated rod	1.5mm
Wire	1mm
Strip	On request
Foil	On request
Braze-pastes	On request
Others	Rings, Preformed Shapes

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