

Technical data

Silver brazing filler metal

Silver-flo™ 33 – Cadmium free silver brazing filler metal

Product description

Silver-flo™ 33 is a cadmium free silver brazing filler metal. It shows free flowing characteristics melting over a short, but comparatively high, temperature range (700-740°C). It is a good brazing filler metal that has been used as the second filler metal in a three step sequential brazing process along with Silver-flo™ 16 and Silver-flo™ 55.

Silver-flo™ 33 is not widely used today. Optimum joint gaps at brazing temperature are 0.075-0.2mm.

Composition: 33%Ag, 33.5%Cu, 33.5%Zn

Conforms to: Proprietary JM specification

Melting range: 700-740°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™ 33. 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 dia
Flux coated rod	On request
Wire	On request
Strip	On request
Foil	On request
Braze-pastes	On request
Others	Rings, Preformed shapes

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