

Technical data

Silver brazing filler metal

Silver-flo™ 45 – Cadmium free silver brazing filler metal

Product description

Silver-flo™ 45 is a cadmium free silver brazing alloy originally developed and manufactured to a Johnson Matthey specification. Today this alloy has been largely superseded by Silver-flo™ 452, and is generally only offered where it is included in an old specification.

Silver-flo™ 45 combines a low brazing temperature with a short melting range. It is very free flowing and produces smooth neat joints with small fillets. The alloy is tin and silicon free. The optimum joint gap at brazing temperature is normally 0.05-0.15mm.

Composition: 45%Ag, 25%Cu, 30%Zn,

Conforms to: Proprietary JM Specification

Melting range: 680-700 °C

Uses for this product

In the past Silver-flo™ 45 was successfully used in reducing atmosphere furnace brazing of brass components producing excellent results when a dew point of -40oC was reached.

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).

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™ 45. 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	On request
Wire	On request
Strip	On request
Foil	On request
Braze-pastes	On request
Others	Rings, Preformed shapes

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