

Technical data

Silver brazing filler metal paste

Silver-flo™ 56 Cadmium free silver brazing paste

Product description

Silver-flo™ 56 brazing paste is a custom made solution for improving the quality and production rate of brazing operations. It consists of Silver-flo™ 56 powder, a cadmium-free silver brazing filler metal, combined with a flux-binder system to form a smooth dispensible paste.

The use of a brazing paste provides the opportunity for automation or semi-automation of the brazing process by de-skilling and allowing pre-placement of the brazing material. It reduces handling, waste and can improve joint quality by helping to provide repeatability in brazing.

The filler metal, Silver-flo™ 56, combines a low brazing temperature with a short melting range is very free flowing and produces neat joints with small fillets. These characteristics make Silver-flo™ 56 an excellent general-purpose silver brazing filler metal.

Silver-flo™ 56 Brazing Paste is an extremely versatile product and has been used in a range of diverse applications from the brazing of electrical contacts, to pipes in musical instruments or the tubes and brackets in shot guns for example.

Composition: 56%Ag, 22%Cu, 17%Zn, 5Sn%

Specification: ISO 17672: 2010 Ag156, EN 1044 AG102, AWS A5.8 BAg-7

Melting range: 618-652 °C

Paste Grades: 106-B1-70, 180-B1-75

Uses for this product

Silver-flo™ 56 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), steels including, mild, carbon, tool steel, stainless steels, low alloy steel), tungsten carbide and PCD segments. On large or difficult to wet tungsten carbide pieces specialised silver brazing filler metals containing nickel / manganese are often preferred.

Conditions for use

Silver-flo™ 56 brazing paste should be pre-placed on the outside of the component and not trapped in the joint. Brazing paste should be heated indirectly using the heat build up in the components to cause it to melt. The optimum joint gap for this filler metal at brazing temperature is normally 0.05-0.15mm. Flux residues should be removed by soaking and then washing in warm water.

Product availability

Braze-pastes On request

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