

## Technical data

### Silver brazing filler metal

#### Argo-braze™ 25DHE – Silver brazing filler metal

#### Product description

Argo-braze™ 25DHE is a cadmium free silver brazing filler metal. It has a long melting range and is useful as a gap filling filler metal producing large fillets. It is, however, prone to liquate (separate into low and high melting constituents) if it is heated slowly through its melting range. For this reason rapid heating methods should be employed wherever possible.

**Composition:** 25% Ag, 52.5%Cu, 22.5%Zn

**Conforms to:** MSRR 9500/ 106 (formerly known as DHE311)

**Melting range:** 675-855 °C.

#### Uses for this product

This product has been used in aerospace applications and as a surface for bearings and seals in jet engine compressors.

#### Conditions for use

This product is designed for brazing in air and should be used in conjunction with a high temperature flux such as Tenacity™ No.5. A rapid heating method such as induction or fixed burner heating is recommended to avoid the problems of liquation.

#### Product availability

Manufactured to order only.

Johnson Matthey Plc cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products will be used. This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is given in good faith, being based on the latest information available to Johnson Matthey Plc and is, to the best of Johnson Matthey Plc's knowledge and belief, accurate and reliable at the time of preparation. However, no representation, warranty or guarantee is made as to the accuracy or completeness of the information and Johnson Matthey Plc assumes no responsibility therefore and disclaims any liability for any loss, damage or injury howsoever arising (including in respect of any claim brought by any third party) incurred using this information.

The product is supplied on the condition that the user accepts responsibility to satisfy himself as to the suitability and completeness of such information for his own particular use. Freedom from patent or any other proprietary rights of any third party must not be assumed. The text and images on this document are Copyright and property of Johnson Matthey. This datasheet may only be reproduced as information, for use with or for resale of Johnson Matthey products. The JM logo®, Johnson Matthey name® and product names referred to in this document are trademarks of Johnson Matthey. Easy-flo® and Silver-flo® are registered to JM in the EU. Sil-fos™ is registered to JM in the UK and certain other countries but is marketed as Mattiphos™ in Germany and the USA.

Johnson Matthey PLC, Platinum Group Metal Services, Orchard Road, Royston, Herts, SG8 5HE, UK Rev.27/01/25.

