

## Technical data

### Silver brazing filler metal

#### Argo-braze™ 64– Silver brazing filler metal

#### Product description

Argo-braze™ 64 is a specialised brazing alloy developed principally for the brazing of tungsten carbide tipped components, which have subsequently to be treated with a PVD (physical vapour deposition) coating such as TiN, TiAlN, TiAlN, or CrN. The brazing alloy is ideal for this type of application, as it does not contain either zinc or cadmium that would be volatile under coating conditions.

Argo-braze™ 64 is relatively low melting and it has reasonable flow characteristics. The alloy contains indium as a melting point depressant and additions of nickel and manganese, elements that have been found to aid wetting and bonding to tungsten carbide. These additions are particularly of use when brazing difficult to wet carbides, low in cobalt or that contain small additions of titanium and or tantalum carbide.

**Composition:** 64%Ag, 26%Cu, 2%Mn, 2%Ni, 6%In

**Conforms to:** Johnson Matthey specification

**Melting range:** 730-780 °C

#### Uses for this product

Most commonly this filler metal is used for brazing of tungsten carbide segments to steel components that will subsequently have a PVD coating applied to them. In particular it has been used in the manufacture of a wide range of tungsten carbide tipped tools and drills.

#### Conditions for use

A standard flux such as Easy-flo™ Flux Powder or Mattiflux™ 100 Flux Paste or special boron modified 'brown' fluxes such as Tenacity™ No. 6 Powder or Paste should be used in conjunction with Argo-braze™ 64.

#### Product availability

Special order only.

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