

Technical data

Silver brazing filler metal

Argo-braze™ 72NiV– Silver brazing filler metal

Product description

Argo-braze™ 72NiV is a modified version of the silver-copper brazing filler metal Argo-braze™ 72V. It has a nominal 0.5% addition of nickel that improves the filler metal's wetting characteristics on ferrous and nickel based parent metals and somewhat reduces the alloy's flow properties making it more sluggish.

Like Argo-braze™ 72V this filler metal can be manufactured to meet vacuum tube grade requirements with low and controlled levels of volatile impurities. Consequently it can be used on vacuum tube devices that operate at moderate temperatures, and where the presence of volatile elements might otherwise be detrimental to the performance of the component

Where ceramics are being brazed to a low expansion nickel alloy care should be taken (nickel plating / stress relieving) to prevent intergranular penetration (liquid metal stress cracking) of the nickel alloy.

Composition: 71.5%Ag, 28%Cu, 0.5%Ni

Conforms to: AWS A5-8 BVAg-8b

Melting range: 780-795 °C

Uses for this product

Argo-braze™ 72NiV is used for brazing silver, copper, nickel and ferrous-based parent metals as well as metalised ceramics. Typical applications include components for vacuum tube devices.

Conditions for use

This product can be used to braze in hydrogen, an inert atmosphere or in a vacuum without the need for a flux. When vacuum brazing a partial pressure brazing technique should be used to prevent the vaporisation of the silver within the alloy.

Product availability

Special order only.

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