

TECHNICAL DATA SHEET

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Identification:	amasan Silver Brazing alloy Ag55Sn coated
Make up:	Flux coated rods 1,5 mm - 3,0 mm
Nominal composition:	Ag 55%; Cu 21%; Sn 2%; Zn 22%
Permitted impurities max.:	Al 0,001; Bi 0,030; Cd 0,010; P 0,008; Pb 0,025; Si 0,05
Density approx.:	9,4 g/cm ³
Tensile strength acc. DIN EN 12797:	St 37: 350 MPa; St 50: 430 Mpa
Elongation approx.:	approx 25%
Electrical Conductivity approx.:	approx 7,0 m/Ωmm ³
Optimal joint gap:	0,05 – 0,15 mm
Solidus - Likwidus:	630 - 660°C
Working temperature approx.:	660°C
Classification:	DIN 8513 L-Ag55Sn
Classification:	ISO 17672 Ag 155 The brazing alloy does not contain any restricted substances as specified in Directive 2011/65/EU ("RoHS"), including lead, cadmium, mercury, hexavalent chromium, PBBs or PBDEs.
Applications:	Ag55Sn is a cadmium-free, silver-based brazing alloy with a low melting temperature and excellent flow characteristics. It is recommended for brazing steel, stainless steel, nickel and its alloys, copper, brass, and tin-zinc bronzes, as well as for joining combinations of these materials. It is also suitable for brazing non-ferrous metal alloys resistant to seawater, for applications in the food industry, and for joining components in vacuum technology (active capillary joints). The brazing alloy is flux-coated with a flux belonging to the FH10 group. The brazing process can be carried out using a flame heating method (torch) or by induction heating. Heat the joint uniformly until the brazing alloy applied to the joint edge melts freely and completely fills the joint gap. When using a separate flux or a flux-coated brazing alloy, any flux residues must be removed after brazing. Ag55Sn brazing alloy provides corrosion resistance and durability of the brazed joint while requiring a relatively small amount of filler metal. The brazed joint is resistant to operating temperatures of up to 200 °C. The tensile strength of joints made using the Ag55Sn alloy generally exceeds the strength of the base materials. However, the final strength of the joint depends on factors such as the type of metals being joined, joint design, brazing gap width, and the correctness of the brazing procedure.
Certificate:	PZH
Note:	The information contained in this Technical Data Sheet is based on the knowledge available to us on the date of the

latest revision of this document and is considered to be accurate. However, none of the information contained herein shall be construed as a guarantee of any product properties. We shall not be held liable for any results obtained or for any damage arising from the use of the information contained in this Technical Data Sheet. We shall also accept no liability for improper use of the product. Users are responsible for verifying, at their own discretion, the suitability and completeness of the information with regard to the specific intended application of the product. As the final use of the product is beyond our direct control, it is the user's responsibility to fully comply with all applicable occupational health and safety laws, regulations and requirements. Detailed information on hazards, properties, safe use and emergency procedures in the event of contact with the mixture is provided in the Safety Data Sheet (SDS).

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