

Technical data sheet

HPW-102Ag

Cadmium free

Norm

| | |
|-----------------------|----------------------|
| DIN EN ISO 17672:2017 | Ag 156 |
| DIN EN 1044:1999 | AG 102 |
| DIN 8513:1979 | L-Ag55Sn |
| EN ISO 3677:2016 | B-Ag56CuZnSn-620/655 |

Composition [Mass friction %]

| Ag | Cu | Zn | Sn |
|----|----|----|----|
| 56 | 22 | 17 | 5 |

Valid impurity [max. mass friction%]

| Al | Bi | Cd | P | Pb | Si | total |
|-------|------|------|-------|-------|------|-------|
| 0,001 | 0,03 | 0,01 | 0,008 | 0,025 | 0,05 | 0,15 |

Technical specification

| | |
|----------------------|-----------------------|
| Melting range | 620-655 °C |
| Solidus | 620 °C |
| Liquidus | 655 °C |
| Working temperature | 650 °C |
| Density | 9,5 g/cm ³ |
| Tensile strength | 400 N/mm ² |
| Heat-resisting up to | approx. 200 °C |

Sources of heat

Flame brazing process, Induction heating and Oven soldering

Application

Steel, Copper and Copper alloy, Nickel und Nickel alloy, Malleable iron

Delivery forms

| | |
|-------------|--|
| Wires | Ø from 0.3 mm to 5.0 mm, available as bunch or on spools |
| Rods bare | Ø from 1.0 mm to 4.0 mm, in length from 50 mm to 1,000 mm (standard 500 mm) |
| Rods coated | standard diameter 1.5 mm, 2.0 mm und 3.0 mm; standard length 500 mm (available with different thickness of flux) |
| Bands | from 0.05 mm thickness, maximum width 70 mm |
| Preforms | made of wires as rings, sections, or bent components in any shape made of band as discs, shims, blanks, or bent components in any shape |
| Flux | According to EN 1045 und EN 29454 on request |

Other dimensions and forms available on request.