

Technical Data Sheet

HPW-104Ag

Cadmium free

Norm

DIN EN ISO 17672:2017	Ag 145
DIN EN 1044:1999	AG 104
DIN 8513:1979	L-Ag45Sn
EN ISO 3677:2016	B-Ag45CuZnSn-640/680

Composition [Mass friction %]

Ag	Cu	Zn	Sn
45	27	25.5	2.5

Valid impurity [max. mass friction %]

Al	Bi	Cd	P	Pb	Si	Ges.
0.001	0.03	0.01	0.008	0.025	0.05	0.15

Technical specification

Melting range	640-680 °C
Solidus	640 °C
Liquidus	680 °C
Working temperature	670 °C
Density	9.2 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.