

Technical Datasheet HPW-138Ag

Cadmium free

Norm

DIN EN ISO 17672:2017	Ag 138
DIN EN 1044:1999	-
DIN 8513:1979	L-Ag-38Sn
EN ISO 3677:2016	B-Ag38CuZnSn-650/720

Composition [mass friction %]

Ag	Cu	Zn	Sn
38	32	28	2

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 Specifications

Melting range	650-720 °C
Solidus	650 °C
Liquidus	720 °C
Working temperature	710 °C
Density	8.9 g/cm ³
Tensile strength	not specified
Heat-resisting up to	approx. 200 °C

Sources of heat

Flame brazing process, Induction heating and Oven soldering

Application

Steel, Copper and Copper alloys, Nickel und Nickel alloys, 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 von 50 mm to 1,000 mm (standard 500 mm)
Rods coated	standard diameter 1.5 mm, 2.0 mm and 3.0 mm; standard 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 band components in any shape made of band as discs, shims, blanks, or bent components in any shape
Flux	according to EN 1045 and EN 29454 on request

Other dimensions and forms available on request.