

Technical Datasheet HPW-202Ag

Cadmium free

Norm

| | |
|-----------------------|--------------------|
| DIN EN ISO 17672:2017 | - |
| DIN EN 1044:1999 | AG 202 |
| DIN 8513:1979 | L-Ag60 |
| EN ISO 3677:2016 | B-Ag60CuZn-695/730 |

Composition [mass friction %]

| Ag | Cu | Zn | Sn |
|----|----|----|----|
| 60 | 26 | 14 | - |

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 | 695-730 °C |
| Solidus | 695 °C |
| Liquidus | 730 °C |
| Working temperature | 710 °C |
| Density | 9.5 g/cm ³ |
| Tensile strength | 450 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 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.