

SILVER BRAZING ALLOYS SELECTION CHART

ALLOY	QQ-B-654A	AMS	AWS A5.8	Ag %	Cu %	Zn%	Ni %	Sn %	OTHER	SOLIDUS		LIQUIDUS		FLUIDITY RATING	TYPICAL APPLICATION
										°F	°C	°F	°C		
Safety-Silv® 25				25	43	30		2		1270	688	1435	779	5	Steel to copper alloys. Dissimilar metals joint should be in compression on cooling.
Safety-Silv® 30	BAG-20		BAG-20	30	38	32				1250	677	1410	766	6	Use with ferrous and non-ferrous base metals. Flow suitable for bridging gaps.
Safety-Silv® 35			BAG-35	35	32	33				1250	677	1350	732	5	Ferrous and non-ferrous base metals. Moderate temperature and good ductility.
Safety-Silv® 38T		4761	BAG-34	38	32	28		2		1220	660	1325	718	7	Low-temperature, free-flowing alloy with exceptional fillet-forming quality. For ferrous and non-ferrous metals.
Safety-Silv® 40				40	30.5	29.5				1250	660	1350	732	5	For steel, nickel, and copper alloys. Suitable for wider clearance yet provides good ductility.
Safety-Silv® 40N2	BAG-4		BAG-4	40	30	28				1220	677	1435	779	4.5	For stainless steel, nickel alloys for corrosion resistance and strength. Good choice for tungsten carbides.
Safety-Silv® 40T			BAG-28	40	30	28		2		1220	660	1310	710	6.5	Good flow properties. Suitable for ferrous and non-ferrous base metals.
Safety-Silv® 45	BAG-5		BAG-5	45	30	25				1225	663	1370	743	6.5	General purpose filler for steel and copper alloys. Melting range useful for wide clearances.
Safety-Silv® 45T			BAG-36	45	27	25		3		1195	646	1265	685	7	Good flow properties. Suitable for ferrous and non-ferrous base metals.
Safety-Silv® 49NM	BAG-22		BAG-22	49	16	23	4.5		(Mn) 7.5	1260	680	1290	699	8	Low temperature alloy for joining carbides and ferrous alloys.
Safety-Silv® 50			BAG-6	50	34	16				1270	688	1425	774	5.5	Often used to braze galvanized steel but suitable for bridging gaps in other ferrous and non-ferrous metals.
Safety-Silv® 50N		4788	BAG-24	50	20	28				1220	660	1305	707	7	Low melting braze alloy with good flow. Primarily used for brazing stainless steel, nickel based alloys, and tungsten carbide inserts.
Safety-Silv® 54		4772	BAG-13	54	40	5	1			1340	726	1575	857		Ideal for use on stainless steel and for wide joint clearances.
Safety-Silv® 56	BAG-7	4763	BAG-7	56	22	17		5		1145	618	1205	652	8	For ferrous and non-ferrous alloys. Often used to braze stainless steel for food service. NSF 51
Safety-Silv® 56N	BAG-13A	4765	BAG-13A	56	40	2				1420	771	1640	893	5	Used in high temperature and furnace applications where zinc fumes are objectionable.
Safety-Silv® 60T	BAG-18	4773	BAG-18	60	Rem			10		1115	602	1325	718	4.5	Used on copper, nickel, and steel with good corrosion resistance.
Safety-Silv® 63T		4774	BAG-21	63	28.5		2.5	6		1275	691	1475	802	5	Zinc-free alloy often used for furnace brazing 300 & 400 series stainless steel. Prevents crevice corrosion on 400 series stainless.
Safety-Silv® 72			BAG-8	72	28					1435	779	1435	779	10	Used in vacuum and atmosphere brazing on ferrous and non-ferrous metals.

VACUUM GRADE HIGH SILVER ALLOYS

ALLOY	AWS A5.8	Ag %	Cu %	Zn %	Ni %	Sn %	OTHER	SOLIDUS		LIQUIDUS	
								°F	°C	°F	°C
Safety-Silv® 72V	BVAg-8	72	28					1435	779	1435	779
Safety-Silv® 99.9 (Pure Silver)	BVAg-0	99.9						1761	961	1761	961

* ISO, EN, DIN, cadmium and other alloys available upon request.