



Av. Guillermo Dansey 2050, Z.I. Conde, Lima - Perú.  
T: (51-1)336-8601 / (51-1)336-8602. F: (51-1)336-7141.

[www.tecnoweld.com.pe](http://www.tecnoweld.com.pe)

## TW-25 (AWS BAg-27)

**Low-cost 25% silver brazing alloy. Suitable for ferrous and non-ferrous metals.**



### APPLICATIONS:

Used for joining carbon steels, alloy steels, stainless steels, nickel, copper, bronze and brass. Ideal for cooling systems, air conditioning units, heat exchangers, control pipes, and metal and dissimilar alloy pipes. Its relatively broad melting range gives it an easy weldability characteristic even when used on imprecise fitting joints. It has a relatively low content of silver making it inexpensive among its kind.

### CHARACTERISTICS:

Melting Range	: Solidus 607°C Liquidus 745°C
Working Temperature	: 745-860°C
Heating Method	: Torch, Furnace, Induction
Tensile Strength	: 39 kg/mm <sup>2</sup> (55,500 PSI)
Elongation in 2"	: 30%
Chemical Composition	: Ag 25%, Cu 35%, Zn 26.5%, Cd 13.5%

### PROCEDURE:

Clean brazing area removing rust or grease. For maximum strength, overlapping joints or square butt joints should be spaced from 0.04 to 0.08 mm. Cover the joint area and the rod tip with flux. If a torch is used, thoroughly heat with a carburizing flame keeping a 1" to 3" distance between the flame zone and the part to be brazed, heating until the flux dissolves. Then, deposit the alloy while keeping the torch in constant movement until the alloy flows completely throughout the joint. Allow to cool slowly and remove all flux residue.

### AVAILABLE FORMS:

Round rods (Ø)	: 1/16", 3/32", 1/8" and other Ø upon request
Length	: 18", 20" or 500 mm