



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

TW-50 (AWS BAg-1a)

50% silver brazing alloy, with excellent fluidity and good tensile strength. Suitable for ferrous and non-ferrous metals.



APPLICATIONS:

Used for carbon steels, steel alloys, stainless steels, nickel, copper and its alloys. Suitable for thin parts and plates, high-speed tools, matrices, pipes, as well as wire mesh and electrical connections. It is recommended for T and square butt joints. Because of its high silver content, it combines the application of low temperature with high mechanical strength and ductility. It has a good corrosion resistance and very good electrical conductivity making it a very versatile alloy.

CHARACTERISTICS:

Melting Range	: Solidus 627°C Liquidus 635°C
Working Temperature	: 627-760°C
Heating Method	: Torch, Furnace, Induction
Tensile Strength	: 45 kg/mm ² (64,300 PSI)
Elongation in 2"	: 29%
Chemical Composition	: Ag 50%, Cu 15.5%, Zn 16.5%, Cd 18%

PROCEDURE:

Clean brazing area removing rust or grease. For maximum strength, overlapping joints or square butt joints should be spaced from 0.03 to 0.08 mm. Heat the brazing area uniformly and evenly with a neutral flame. Add flux and continue heating until it liquefies. Apply the brazing alloy until it flows completely throughout the joint. Perform the brazing process quickly to prevent alloy losses. Allow to cool slowly and remove all flux residue with hot water.

AVAILABLE FORMS:

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