



## Silver-flo™ 55 – Cadmium Free Silver Brazing Filler Metal

Silver-flo™ 55 is a cadmium free silver brazing filler metal. It combines a low brazing temperature with a short melting range. Silver-flo™ 55 is very free flowing and produces neat joints with small fillets. These characteristics make Silver-flo™ 55 an excellent general-purpose silver brazing filler metal. In many countries it is accepted as the best cadmium-free alternative to the low-melting cadmium containing filler metals. For example, it is used as a substitute for alloys such as Easy-flo™ and Easy-flo™ No.2.

Joints made with Silver-flo™ 55 are suitable for seawater applications, being resistant to dezincification. The optimum joint gap for this filler metal at brazing temperature is normally 0.05-0.15mm.

<b>Composition:</b>	55%Ag, 21%Cu, 22%Zn, 2Sn%
<b>Specification:</b>	ISO 17672 Ag 155, EN 1044 1999 AG103, MSRR 9500/708
<b>Melting range:</b>	630-660°C

### Uses for this Product

Silver-flo™ 55 can be used to join all the common engineering materials (excluding aluminium) such as copper, copper alloys (including, brasses, bronzes, gun metal, nickel silvers, aluminium bronze, copper nickel), steels including, mild, carbon, tool steel, stainless steels, low alloy steel), tungsten carbide and PCD segments. On large or difficult to wet tungsten carbide pieces specialised silver brazing filler metals containing nickel / manganese are often preferred.

### Conditions for Use

This filler metal is mainly used for brazing in air with a flux. In most cases Easy-flo™ Flux can be used in conjunction with Silver-flo™ 55. However, flux selection is application dependent. Please refer to JM technical department or flux product datasheets before selecting a flux.

### Product Availability

Rod	1mm, 1.5mm, 2mm, 2.5mm, 3mm, 4mm
Flux Coated Rod	1.5mm, 2mm, 2.5mm
Wire	0.5mm, 0.75mm, 0.9mm, 1mm, 1.2mm, 1.5mm, 2mm
Strip	5 x 1mm, 3 x 1mm, 1.5 x 1mm
Foil	80 x 0.25mm, 80 x 0.12mm, 12.7 x 0.127mm, 25 x 0.25mm
Braze-pastes	On request
Others	Rings, Preformed Shapes

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