

SILVALOY® Brazing Alloys Reference Chart

	AWS	Nominal Chemical Composition								Melting Point	Flow Point	
	A5.8	SILVALOY	Ag	Cu	Zn	Cd	P	Ni	Sn	Mn	°F	°F
Cu-P Family	BCuP-2	0	0	92.75			7.25				1310	1350
	BCuP-6	2	2	91			7				1190	1300
	BCuP-3	5	5	89			6				1190	1325
	BCuP-7	5F	5	88.25			6.75				1190	1300
		6	6	88			6				1190	1325
	BCuP-4	6F	6	86.75			7.25				1190	1275
	BCuP-5	15	15	80			5				1190	1300
		18M	18	75.75			6.25				1190	1220
	BAG-1	45	45	15	16	24					1125	1145
Ag-Cu-Zn Family		A75	75	22	3						1365	1450
	BAG-10	A70	70	20	10						1275	1360
	BAG-9	A65	65	20	15						1240	1325
		A60	60	25	15						1245	1345
	BAG-6	A50	50	34	16						1250	1425
	BAG-5	A45	45	30	25						1225	1370
		A40	40	36	24						1235	1415
		A40L	40	30.5	29.5						1245	1340
	BAG-35	A35	35	32	33						1260	1390
	BAG-20	A30	30	38	32						1250	1410
		A25	25	52.5	22.5						1250	1575
		A20	20	45	35						1315	1500
	A9	9	53	38						1410	1565	
	A5	5	58	37						1545	1615	
Ag-Cu-Zn-Ni Family	BAG-13	A54N	54	40	5			1			1325	1575
	BAG-24	A50N	50	20	28			2			1220	1305
	BAG-4	A40N2	40	30	28			2			1220	1435
		A40N5	40	30	25			5			1220	1580
	BAG-22	A49NM	49	16	23			4.5	7.5		1260	1290
Ag-Cu-Zn-Sn Family	BAG-7	A56T	56	22	17				5		1145	1205
		A50T	50	22	25				3		1190	1230
	BAG-36	A45T	45	27	25				3		1195	1270
	BAG-28	A40T	40	30	28				2		1200	1310
	BAG-34	A38T	38	32	28				2		1200	1330
	BAG-37	A25T	25	40	33				2		1265	1420
Ag-Cu- Family	BAG-8	B72	72	28							1435	1435
		B72N	71.5	28				0.5			1435	1450
	BAG-13a	B56N	56	42				2			1420	1640
	BAG-18	B60T	60	30					10		1115	1325
		B7T	7	85					8		1225	1805
	Z75	75		25							1300	1345

SILVALOY® Specification Check List

SOURCE OF NUMBER AND SPECIFICATION				SILVALOY BRAZING ALLOY
AWS A5.8	Federal Specification QQ-B-654A	ASME Boiler & Pressure Vessel Code Sec. II P&C SFA5.8	Society of Automotive Engineers Aeronautic Material Spec.	
BCuP-2		BCuP-2		0
BCuP-3		BCuP-3		5
BCuP-4		BCuP-4		6F
BCuP-5	BCuP-5	BCuP-5		15
BCuP-6		BCuP-6		2
BCuP-7		BCuP-7		5F
BAG-1	VII	BAG-1	AMS4769	45
BAG-1a	IV	BAG-1a	AMS4770	50
BAG-2	VIII	BAG-2	AMS4768	35
BAG-2a		BAG-2a		30
BAG-3	V	BAG-3	AMS4771	50N
BAG-4	BAG-4	BAG-4		A40N2
BAG-5	BAG-5	BAG-5		A45
BAG-6		BAG-6		A50
BAG-7	BAG-7	BAG-7	AMS4763	A56T
BAG-8		BAG-8		B72
BAG-9	BAG-9	BAG-9		A65
BAG-10	BAG-10	BAG-10		A70
BAG-13		BAG-13	AMS4772	A54N
BAG-13a	BAG-13a	BAG-13a	AMS4765	B56N
BAG-18	BAG-18	BAG-18	AMS4773	B60T
BAG-20	BAG-20	BAG-20		A30
BAG-22	BAG-22	BAG-22		A49MN
BAG-24		BAG-24	AMS4788	A50N
BAG-27		BAG-27		25
BAG-28		BAG-28		A40T
BAG-33		BAG-33		25L
BAG-34		BAG-34	AMS4761	A38T
BAG-35		BAG-35		A35
BAG-36		BAG-36		A45T
BAG-37		BAG-37		A25T
AWS FB3-A	FED. SPEC. O-F-499 TYPE-B		AMS3410	ULTRA FLUX®
AWS FB3-C	FED. SPEC. O-F-499 TYPE-B		AMS3411	BLACK FLUX™

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