

SILVALOY® Brazing Alloys Reference Chart

European Version

W	EN										Melt	Flow	Working
	1044:2000	SILVALOY	Ag	Cu	Zn	Cd	P	Ni	Sn	Other	°C	°C	°C
Cu-P	CP203	0LP	0	94			5.9 - 6.5				710	890	760
		0	0	92.75			7.0 - 7.5				710	820	730
	CP201	0HP	0	92.2			7.6 - 8.0				710	770	720
	CP105	2M	2	91.5			6.3 - 6.7				645	825	740
		2S	2	92			6.3 - 6.7			trace Si	645	825	740
	CP104	5	5	89			5.8 - 6.2				645	815	710
		5S	5	89			5.8 - 6.2			trace Si	645	815	710
	CP102	15	15	80			4.7 - 5.3				645	800	700
	18M	18	75.75			6.0 - 6.5				645	660	650	
Ag-Cu-Zn-Cd	AG309	20	20	40	25	15					605	765	750
		25	25	35	27	13					605	745	730
		34	34	22	24	20					610	680	640
	AG304	40	40	19	21	20					595	630	610
		45	45	15	16	24					605	615	605
	AG351	50N	50	15.5	16	16		3			630	685	650
Ag-Cu-Zn		A9	9	53	38						765	850	830
	AG206	A20S	20	44	36					.15 Si	690	810	810
		A25	25	52.5	23						675	855	835
	AG204	A30	30	38	32						680	765	750
		A35	35	32	33						680	750	730
	AG203	A44	44	30	26						675	735	730
		A65	65	20	15						670	720	710
		A70	70	20	10						690	735	720
Ag-Cu-Zn-Ni		A40N2	40	30	28			2			660	780	780
	AG502	A49NM	49	16	23			4.5		7.5 Mn	680	705	690
		A49NM2	49	27	21			0.5		2.5 Mn	670	690	690
		A50N	50	20	28			2			660	750	740
Ag-Cu-Zn-Sn	AG108	A25T	25	40	33				2		680	760	750
	AG107	A30T	30	36	32				2		665	755	740
	AG106	A34T	34	36	27.5				2.5		630	730	710
		A38T	38	32	28				2		650	720	700
	AG105	A40T	40	30	28				2		650	710	690
	AG104	A45T	45	27	25				3		640	680	670
	AG103	A55T	55	21	22				2		630	660	660
		A55TS	55	21	22				2	.15 Si	630	660	660
	Ag-Cu	AG401	B72	72	28							780	780

- All alloys available as wire and rod, most alloys available as foil
- Standard wire/rod sizes 0.5, 0.8, 1.0, 1.2, 1.5, 2.0, 2.2, 2.5, 3.0 mm (others available)
- Standard foil thicknesses 0.2, 0.25, 0.3, 0.4, 0.5, 0.8 (others available) / widths to 125 mm
- Most alloys available as rings, washers, discs and custom preform shapes
- Many alloys available as Flux Coated rods / Flux Cored wire

Specialty Alloys for Hard Metal, Electronic, Catalyst, and Jewelry Brazing

W	EN 1044:2000		Ag Cu Zn Cd Ni Mn						HARD METAL BRAZING ALLOYS			
	PLYMETAL								Melt °C	Flow °C	Working °C	
PLYMETAL	A49NM2		49	27	21		0.5	2.5	Standard gauges 0.3, 0.4, 0.5, 0.8 mm Widths from 1.3 - 100 mm Available in coils or spools	670	690	690
	A50N		50	20	28		2			660	750	740
	AG351	50N	50	15.5	16	16	3			630	685	650

W	EN 1044:2000		Ag Cu Zn P Ni Sn						ELECTRICAL ALLOYS			
	SILVATECH™								Melt °C	Flow °C	Working °C	
ELECTRICAL ALLOYS	CP102	15	15	80		5			Electrical Component applications Any conductivity and resistivity Available in wire, strip, preforms	645	800	700
	A50N		50	20	28		2			660	750	740
	AG402	B60T	60	30				10		600	730	720
	AG401	B72	72	28						780	780	780

W	EN 1044:2000		Ag Cu		SILVER ALLOYS		
	SILVALOY						
SILVER ALLOYS	Fine Silver		99.99		High Purity		
	Fine Silver		99.90		Use for Electrical applications		
	Sterling Silver		92.5	7.5	Use for Jewelry applications		
	Coin Silver		90	10	Use for Jewelry and Industrial applications		

W	EN 1044:2000		Ag Cu P			CATALYST ALLOYS	
	SILVACAT™						
CATALYST ALLOYS	GX 10		10	87	3	Specialty catalyst alloy for manufacturing glyoxal	

W	EN 1044:2000		SILVER BRAZING FLUX				Melt °C	Max Eff. °C
	WOLVERINE							
FLUX	ULTRA FLUX®		Use on all metals except aluminum, magnesium, and titanium				590	870
	BLACK FLUX™		Use on refractory metals, stainless steel, and long heating cycles				590	980

W	EN 29454		Ag Cu Sn			LEAD-FREE SOLDER		Melt °C	Flow °C
	WOLVERINE								
LEAD-FREE SOLDER	97-3™			3	97	Suitable for most plumbing applications		230	250
	SILVABRITE®		4		96	Fast melting, free flowing for field repair		220	220
	SILVABRITE S™		5		95	Wider working range for field repair		220	280
	SILVABRITE 100®		0.4	4	95.6	Lead & antimony free for drinking water systems		225	305

