235 Kilvert Street
Warwick, RI 02886

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PRODUCT: SILVACAP (ALLOY 35490)

COMPOSITION:

Phosphorus	6.5 wt%
Copper	86.4 wt%
Silicon	0.1 wt% max
Tin	7.0 wt%
Total other elements	0.15 wt% Max.

MATERIAL PROPERTIES:

Solidus	1175°F (635°C)
Liquidus	1250°F (677°C)
Brazing Range	1250-1300°F (677-705°C)
Specific Gravity	7.880
Density (toz/cu. in.)	4.153
Color	Matt Gray

DESCRIPTION:

SILVACAP is a low brazing temperature, cadmium-free alloy. It has a slight plastic range which may be noticed during melting on some applications.

APPLICATIONS:

Typical applications are the joining of copper assemblies with close joint clearances.

AVAILABLE FORMS:

SILVACAP is available in rod form.

PRODUCT: **SILVACAP – CONTINUED (ALLOY 35490)**

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength using **SILVACAP** will surpass the strengths of the base metals. Strength is a function of the base metals being joined, type of joint, design of joint, joint clearances and brazing procedures. The recommended maximum operating temperature for **SILVACAP** alloy is up to 400°F in continuous service and up to 600°F in intermittent service.

SAFETY INFORMATION:

It is essential that adequate ventilation be provided so that personnel will not inhale gases and fumes while brazing. The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information, refer to the Material Safety Data Sheet for **SILVACAP**.

LIABILITY-DISCLAIMER:

Wolverine Joining Technologies, LLC, seeks to represent reliable information concerning the composition, properties and use of its products. The technical information provided in this publication is provided at no charge and is without guarantee, warranty or responsibility of any kind, expressed or implied.

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