



235 Kilvert Street
Warwick, RI 02886

A World-Class Quality Partner
ISO 9001:2000
Certified

**PRODUCT: SILVACORE[®] A38T FLUX CORED
(AWS BAg-34)**

COMPOSITION:

Silver	32.3 wt%
Copper	27.2 wt%
Zinc	23.8 wt%
Tin	1.7 wt%
Flux	15.0 wt%
Total Other Elements	0.15 wt% Max.

Flux Composition:

Potassium Bifluoride	27.0%
Potassium Fluoroborate	25.0%
Boric Acid	27.0%
Potassium Tetraborate	21.0%

MATERIAL PROPERTIES:

Solidus	1200°F (649°C)
Liquidus	1330°F (721°C)
Brazing Range	1330-1550°F (721-843°C)
Specific Gravity	5.935
Density (toz/cu. in.)	3.128
Electrical Conductivity (% IACS)	18.0
Electrical Resistivity (Microhm-cm)	9.50
Color	Pale Yellow

DESCRIPTION:

The tin content provides good wetting on many difficult to wet metals such as stainless steel and tungsten carbide. This alloy, being free of Pb or Cd is preferred for long heating cycles and is suitable for use in controlled atmosphere brazing without flux.

APPLICATIONS

Typical applications are the joining of ferrous, nonferrous and dissimilar metals and alloys with close joint clearances. **SILVACORE A38T** is used for joining ferrous metals (stainless steel, Tungsten or molybdenum carbide), and nonferrous (copper, copper alloys, nickel, nickel alloys). The largest use of this alloy is for furnace brazing although it is also suitable for other brazing procedures.



**PRODUCT: SILVACORE® A38T FLUX CORED - CONTINUED
(AWS BAg-34)**

SPECIFICATIONS: Metal

AWS A5.8

BAg-34

AVAILABLE FORMS:

Standard forms of **SILVACORE A38T** are wire and preforms.

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength when using **SILVACORE® A38T** 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 **SILVACORE A38T** is up to 400°F in continuous service and up to 600°F in intermittent service. Where improved corrosion resistance is needed, either **SILVACORE® A50N** or **SILVALOY® A50N** is recommended over silver base filler metals not containing nickel.

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, Cutting). For more complete information, refer to the Material Safety Data Sheet for **SILVACORE A38T** Flux Cored.

LIABILITY-DISCLAIMER:

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