



235 Kilvert Street
Warwick, RI 02886

A World-Class Quality Partner
ISO 9001:2008
Registered

PRODUCT: **SILVACOTE® A34T**
(EN 1044 AG 106)

COMPOSITION:

Silver	30.77 wt%
Copper	32.58 wt%
Zinc	24.89 wt%
Tin	2.26 wt%
Flux	9.50 wt%
Total other elements	0.15 wt% Max.

The Flux Coating for **SILVACOTE® A34T** is a proprietary formulation consisting of: Bifluoride, Fluoborate, Boric Acid, Boron, and a binder.

MATERIAL PROPERTIES:

Solidus	1165°F (630°C)
Liquidus	1345°F (730°C)
Brazing Range	1345-1550°F (730-845°C)
Specific Gravity	5.910
Density (toz/cu in)	3.114
Electrical Conductivity (% IACS)	17.5
Electrical Resistivity (Michroh-m-cm)	9.60
Color (flux coating)	White

DESCRIPTION:

SILVACOTE alloys have a very flexible flux coating that will not crack, flake, or fall off the brazing filler metal. It leaves little to no residue which minimizes joint clean up, and only applies the needed amount of flux for the joint being brazed. The tin content in **SILVACOTE A34T** 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:

SILVACOTE A34T is used for joining ferrous metals, copper, copper alloys, nickel, nickel alloys and combinations of these metals. The best application for **SILVACOTE** is induction or torch brazing.



PRODUCT: **SILVACOTE® A34T - CONTINUED**
(EN 1044 AG 106)

SPECIFICATIONS:

EN 1044 AG 106

AVAILABLE FORMS:

Standard form of **SILVACOTE A34T** is wire. Also available in spools, coils, or canister.

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength when using **SILVACOTE A34T** 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 **SILVACOTE A34T** is up to 400°F in continuous service and up to 600°F in intermittent service. Where improved corrosion resistance is needed **SILVACOTE® 50N** and **SILVACOTE® A40N2** are recommended over silver brazing 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 **SILVACOTE A34T**.

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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