



235 Kilvert Street
Warwick, RI 02886

A World-Class Quality Partner
ISO 9001:2000
Certified

PRODUCT: **SILVALOY[®] A35**
(AWS BAg-35)

COMPOSITION:

| | |
|----------------------|---------------|
| Silver | 35.0 wt% |
| Copper | 32.0 wt% |
| Zinc | 33.0 wt% |
| Total Other Elements | 0.15 wt% Max. |

MATERIAL PROPERTIES:

| | |
|----------------------------------|-------------------------|
| Solidus | 1265°F (685°C) |
| Liquidus | 1390°F (754°C) |
| Brazing Range | 1390-1545°F (754-841°C) |
| Specific Gravity | 8.668 |
| Density (T.oz./cu.in.) | 4.568 |
| Electrical Conductivity (% IACS) | 22.0 |
| Color | Yellow White |

DESCRIPTION:

SILVALOY A35 is a good general purpose alloy often used when cadmium must be avoided such as in the dairy and food industries.

APPLICATIONS:

Typical applications are the joining of ferrous, non-ferrous and dissimilar metals and alloys with close joint clearances. It is mostly used for brazing in the electrical industry and for brazing brass parts such as ships, piping, band instruments, lamps, etc.

SPECIFICATIONS:

AWS A5.8

BAg-35



PRODUCT: **SILVALOY[®] A35 - CONTINUED**
AWS BA_g-35

AVAILABLE FORMS:

Standard forms of **SILVALOY A35** are wire, strip, powder and preforms.

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength when using **SILVALOY A35** 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 **SILVALOY A35** is up to 400°F in continuous service and up to 600°F in intermittent service. When improved corrosion resistance is needed, **SILVALOY[®] 50N** and **SILVALOY[®] A40N2** are 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, and Cutting". For more complete information, refer to the Material Safety Data Sheet for **SILVALOY A35**.

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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