



235 Kilvert Street
Warwick, RI 02886

A World-Class Quality Partner
ISO 9001:2000
Certified

PRODUCT: **SILVALOY[®] A40N2**
(AWS BAg-4)

COMPOSITION:

Silver	40.0 wt%
Copper	30.0 wt%
Zinc	28.0 wt%
Nickel	2.0 wt%
Total Other Elements	0.15 wt% Max.

MATERIAL PROPERTIES:

Solidus	1240°F (670°C)
Liquidus	1435°F (780°C)
Brazing Range	1435-1650°F (780-900°C)
Specific Gravity	8.968
Density (t.oz./cu in)	4.726
Color	Light Yellow

DESCRIPTION:

SILVALOY A40N2 is a cadmium free silver brazing alloy. Addition of nickel to the silver-copper zinc alloy imparts corrosion properties which retards joint or interface corrosion of the brazed assembly. **SILVALOY A40N2** is a suitable replacement to cadmium containing alloys.

APPLICATIONS:

Typical applications are the joining of 300 series stainless steels in the food, medical, and dental fields. The nickel element in **SILVALOY A40N2** also improves the bond strength when joining of tungsten carbide cutting tips.

SPECIFICATIONS:

AWS A5.8	BAg-4
ASME	BAG-4



**PRODUCT: SILVALOY[®] A40N2 - CONTINUED
(AWS BAg-4)**

AVAILABLE FORMS:

Standard forms of SILVALOY A40N2 are wire, strip, and preforms.

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength using SILVALOY A40N2 will usually 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 A40N2 is up to 700°F (370°C).

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 A40N2.

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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