



235 Kilvert Street
Warwick, RI 02886

A World-Class Quality Partner
ISO 9001:2008
Registered

PRODUCT: **SILVALOY[®] A40T**
(AWS BAg-28)

COMPOSITION:

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

MATERIAL PROPERTIES:

Solidus	1200°F (649°C)
Liquidus	1310°F (710°C)
Brazing Range	1310-1550°F (618-760°C)
Specific Gravity	8.801
Density (toz/cu.in.)	4.638
Electrical Conductivity (% IACS)	18.0
Electrical Resistivity (Michroh-m-cm)	9.60
Color	Pale Yellow

DESCRIPTION:

SILVALOY A40T is a good general purpose, low melting, cadmium-free alloy, often selected for its low temperature, wetting and good flow. **SILVALOY A40T** has a lower brazing temperature with a relatively narrower melting range than other cadmium-free classifications with similar silver content. It does not liquate excessively if heated slowly through its melting range.

APPLICATIONS:

Typical applications are the joining of ferrous, nonferrous and dissimilar metals and alloys with close joint clearances. This alloy is particularly useful for joining steel, copper and copper alloys. It has proven most suitable for torch brazing with manual feeding into a joint where heating may not be consistent. It is also suitable for pre-placing as a ring or punching.

SPECIFICATIONS:

AWS A5.8

BAg-28



PRODUCT: **SILVALOY[®] A40T - CONTINUED**
(AWS BA_g-28)

AVAILABLE FORMS:

Standard forms of **SILVALOY A40T** are wire, strip, and preforms

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength using **SILVALOY A40T** 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 A40T** is up to 400°F in continuous service and up to 600°F in intermittent service. Where 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 A40T**.

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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