



235 Kilvert Street
Warwick, RI 02886

A World-Class Quality Partner
ISO 9001:2008
Registered

**PRODUCT: SILVALOY A45 FLUX COATED ROD
(AWS BAg-5)**

COMPOSITION:

Silver	26.03 wt%
Copper	17.35 wt%
Zinc	14.46 wt%
Flux	42.16 wt%
Total other elements	0.15 wt% Max

Flux Composition:

Potassium Bifluoride	10-30%
Potassium Fluoroborate	5-20%
Potassium Tetraborate	15-25%
Potassium Fluoride	5-15%
Boric Acid	25-40%
Water	15-35%

MATERIAL PROPERTIES:

Solidus	1225°F (663°C)
Liquidus	1370°F (743°C)
Brazing Range	1370-1550°F (743-843°C)
Specific Gravity Braze filler metal only	8.972
Density (T.oz./cu.in.) Braze filler metal only	4.728

DESCRIPTION:

SILVALOY A45 FC is a good general purpose alloy often used when cadmium must be avoided such as in the dairy and food industries. It is also used for brazing in the electrical industry and for brazing brass parts such as ships, piping, band instruments and lamps. Generally, the joint strength using **SILVALOY A45 FC** will surpass the strengths of the base metals. The recommended maximum operating temperature for **SILVALOY A45 FC** is up to 400°F in continuous service and up to 600°F in intermittent service. The flux coating is a water base mixture consisting of potassium salts of fluorine and boron. When the rod is placed into the torch flame, the flux will melt several hundred degrees before the alloy, flowing onto the work surface and preparing the surface for the subsequent melting of the braze alloy.



**PRODUCT: SILVALOY A45 FLUX COATED ROD - CONTINUED
(AWS BAg-5)**

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 A45 FC**.

AVAILABLE FORMS:

Standard forms of **SILVALOY A45 FC** is rod.

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.

Wolverine Joining Technologies, LLC
235 Kilvert Street
Warwick, RI 02886
401-739-9550/fax 401-739-9555
www.silvaloy.com