



235 Kilvert Street
Warwick, RI 02886

A World-Class Quality Partner
ISO 9001:2000
Certified

**PRODUCT: SILVALOY® A45T
(AWS BAg-36)**

COMPOSITION:

Silver	45.0 wt%
Copper	27.0 wt%
Zinc	25.0 wt%
Tin	3.0 wt%
Total other elements	0.15 wt% Max.

MATERIAL PROPERTIES:

Solidus	1195°F (645°C)
Liquidus	1251°F (677°C)
Brazing Range	1251-1495°F (677-813°C)
Specific Gravity	8.911
Density (T.oz./cu.in.)	4.696
Electrical Conductivity (% IACS)	18.0
Electrical Resistivity (Michroh-m-cm)	9.60
Color	Pale Yellow

DESCRIPTION:

SILVALOY A45T is a free flowing, low melting and an excellent substitute to the cadmium-bearing filler metals with similar silver contents. **SILVALOY A45T** narrow melt range (75°F) makes it suitable for manual or machine feeding into the braze joint. The alloy is best suited for narrow gap filling in the range of .001-.005 inches.

APPLICATIONS:

Typical applications are the joining of ferrous, nonferrous and dissimilar metals and alloys with close joint clearances. **SILVALOY A45T** is particularly useful in joining steel, copper, copper alloys; and should be used in conjunction with Ultra Flux. The ability to join similar as well as dissimilar metals has allowed for numerous applications in the refrigeration and air conditioning fields.

SPECIFICATIONS:

AWS A5.8	BAg-36
ASME	BAg-36



PRODUCT: **SILVALOY[®] A45T – CONTINUED**
(AWS BAg-36)

AVAILABLE FORMS:

Standard forms of **SILVALOY A45T** are wire and preforms.

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength using **SILVALOY A45T** 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 A45T** is up to 400°F in continuous service and up to 600°F in intermittent service.

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 A45T**.

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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