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TW-35CF (DIN L-Ag34Sn)

Cadmium-free 35% silver brazing alloy. Suitable for hospital and food industry facilities.



APPLICATIONS:

Used for nickel, copper alloy and general steel works. Ideal for cooling systems, air conditioning units, control pipes, dissimilar metal pipes and heat exchangers, cold and hot water pipes, oil pipes, medicinal gas pipes, liquefied gas pipes and natural gas pipes. A cadmium-free alloy, it can be used in the food industry as well as for surgical instruments in hospital facilities.

This is an intermediate temperature brazing alloy of moderate fluidity, good ductility and with a great capacity to withstand high vibrations as well as high working pressures. Its relatively broad melting range gives it an easy weldability characteristic even when used on imprecise fitting joints. Excellent for joining dissimilar metals.

CHARACTERISTICS:

Melting Range	: Solidus 630°C / Liquidus 730°C
Working temperature	: 710°C
Heating Method	: Torch, Furnace, Induction
Heating Strength	: 48 kg/mm ² (68,300 psi)
Elongation en 2"	: 25%
Chemical Composition	: Ag 35%, Cu 36%, Zn 26%, Sn 3%

PROCEDURE:

Clean brazing area removing rust or grease. For maximum strength, overlapping joints or square butt joints should be spaced from 0.04 to 0.08mm. Cover the joint area and the rod tip with flux. If a torch is used, thoroughly heat with a carburizing flame keeping a 1" to 3" distance between the flame zone and the part to be brazed, heating until the flux dissolves. Then, deposit the alloy while keeping the torch in constant movement until the alloy flows completely throughout the joint. Allow to cool slowly and remove all flux residue.

AVAILABLE FORMS:

Round rods (Ø)	: 11/16", 3/32", 1/8"
Lengths	: 18", 20" or 500 mm