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TW-45 (AWS BAg-1)

Brazing alloy with excellent fluidity, low working temperature and high mechanical strength. Suitable for ferrous and non-ferrous metals.



APPLICATIONS:

Used for stainless steel, special steel, carbide, nickel, brass, copper and copper alloy production, maintenance and recovery joints. Suitable for the mass production of instruments, manufacturing of equipment and electrical systems, gas pipelines, cooling facilities, as well as thermally treated parts, high-speed tools, matrices, thin wall pipes, wire mesh, faucets, and metal and dissimilar alloy cooling pipes where the use of excessive temperature is detrimental.

CHARACTERISTICS:

Melting Range	: Solidus 607°C / Liquidus 618°C
Working temperature	: 620-700°C
Heating Method	: Torch, Furnace, Induction
Heating Strength	: 50 kg/mm ² (71,100 psi)
Elongation en 2"	: 35%
Chemical Composition	: Ag 45%, Cu 15%, Zn 16%, Cd 24%

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)	: 1/16", 3/32", 1/8" and other Ø upon request
Lengths	: 18", 20" or 500 mm