



# TW-595

(ASTM B32-08 Sn95)

## Description:

- 95-5 tin-silver soft solder, suitable for hydro-sanitary installations, electric components and high working temperatures.

## Applications:

- Specially developed to solder electrical components and accessories exposed to high operating temperatures.
- Used for copper, copper alloys and stainless-steel works, particularly to sold food industry, cooling and air conditioning equipment, as well as equipment used in the manufacturing of instruments, jewelry, and electrical work where greater conductivity is required.
- Ideal for equipment and hot water copper pipes that will be in contact with food.
- The silver content improves ductility, tensile strength and corrosion resistance.
- Non-toxic as it does not contain lead.

## Characteristics:

<b>Working Temperature</b>	220°C
<b>Heating Method</b>	Torch, furnace, induction
<b>Tensile Strength</b>	10 kg/mm <sup>2</sup> (14,200 psi)
<b>Elongation in 2"</b>	45%
<b>Chemical Composition</b>	Ag 5%, Sn 95%

## Procedure:

1. Clean brazing area removing rust or grease. Use torch with a natural flame.
2. Add flux on soldering area and heat until the flux activates.
3. Add the alloy which should flow quickly.
4. Allow to cool slowly and remove all flux residue.

## Available forms:

Spools x 500g.

1/8" (3.2 mm)



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