

TW-25CF

(AWS BAg-26)

Description:

- General purpose 25% silver brazing alloy. Suitable for ferrous and non-ferrous metals.

Applications:

- Excellent for joining metals of different chemical composition, for nickel, copper and its alloys, alloy steel and stainless steel work.
- Its relatively broad melting range gives it an easy weldability characteristic even when used on imprecise fitting joints. It has a relatively low content of silver making it inexpensive among its kind.
- Ideal for cooling systems, air conditioning units, heat exchangers, control pipes, and dissimilar metal pipes.

Characteristics:

Melting Range	Solidus 685°C / Liquidus 754°C
Working Temperature	755 - 840°C
Heating Method	Torch, furnace, induction
Tensile Strength	39 kg/mm ² (55,500 psi)
Elongation in 2"	30%
Chemical Composition	Ag 25%, Cu 38%, Zn 33%, Ni 2%, Mn 2%

Procedure:

1. 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.
2. Cover the joint area and the rod tip with flux.
3. 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.
4. Then, deposit the alloy while keeping the torch in constant movement until the alloy flows completely throughout the joint.
5. Allow to cool slowly and remove all flux residue.

Available forms:

Round rods (Ø)	1/16" (1.6mm), 3/32"(2.4mm), 1/8" (3.2mm)
Foil	0.05" x 1/8" (1.3x3.2mm)
Lengths	18" (457mm), 20" (508mm) y 500mm