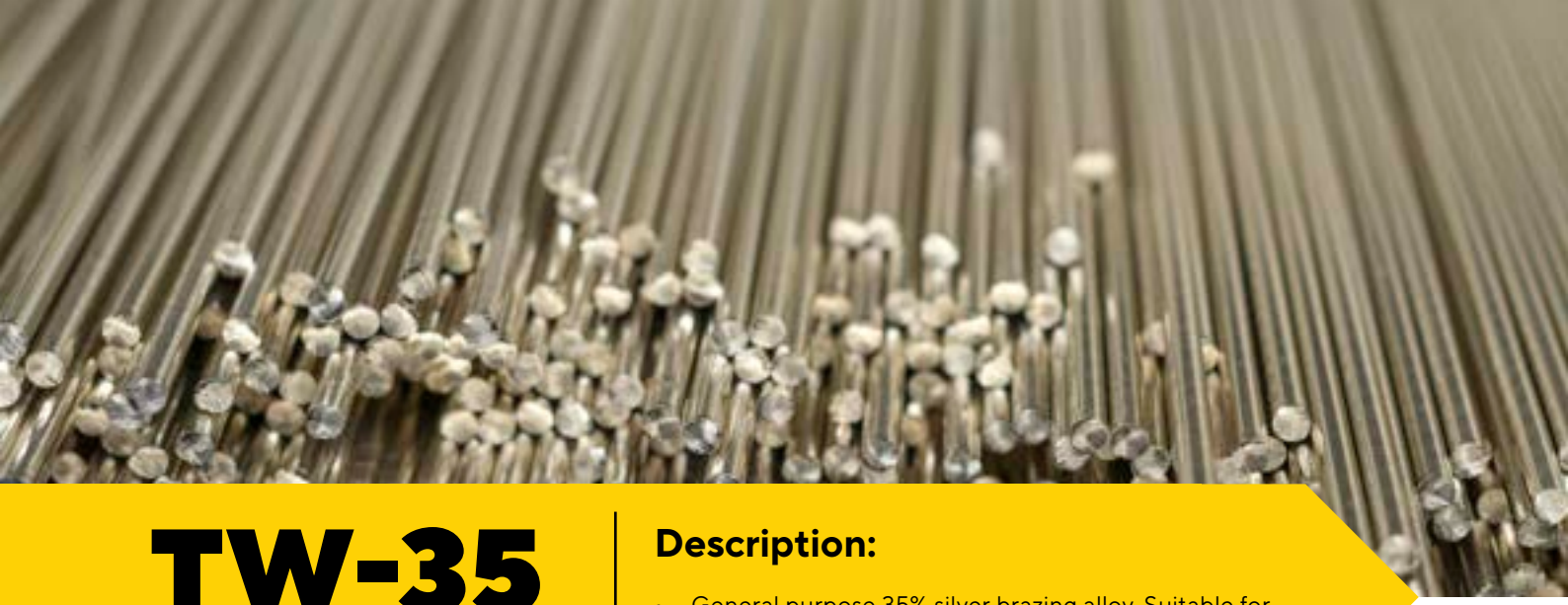

TW-35
(AWS BAg-35)

Description:

- General purpose 35% 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.
- It is an intermediate temperature brazing alloy capable of withstanding high and continuous 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.
- 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	45 kg/mm² (64,000 psi)
Elongation in 2"	32%
Chemical Composition	Ag 35%, Cu 32%, Zn 33%

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

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