

TW-45Sn

(AWS BAg-36)

Description:

- 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 646°C / Liquidus 677°C
Working Temperature	680 - 815°C
Heating Method	Torch, furnace, induction
Tensile Strength	50 kg/mm ² (71,100 psi)
Elongation in 2"	35%
Chemical Composition	Ag 45%, Cu 27%, Zn 25%, Sn 3%

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

