

# TW-50

(AWS BAg-6)

## Description:

- Brazing alloy with 50% silver, excellent fluidity and high mechanical strength. Suitable for ferrous and non-ferrous metals.

## Applications:

- Used for carbon steels, steel alloys, stainless steels, nickel, copper and its alloys. Suitable for thin parts and plates, high-speed tools, matrices, pipes, as well as wire mesh and electrical connections.
- It is recommended for T and square butt joints. Because of its high silver content, it combines the application

of low temperature with high mechanical strength and ductility. It has a good corrosion resistance and very good electrical conductivity making it a very versatile alloy.

## Characteristics:

<b>Melting Range</b>	Solidus 688°C / Liquidus 774°C
<b>Working Temperature</b>	775 - 870°C
<b>Heating Method</b>	Torch, furnace, induction
<b>Tensile Strength</b>	45 kg/mm <sup>2</sup> (64,300psi)
<b>Elongation in 2"</b>	29%
<b>Chemical Composition</b>	Ag 50%, Cu 34%, Zn 16%

## 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:

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