

Lucas-Milhaupt Silvalloy® 45 Flux Coated Rod Brazing Alloy

Category : Metal , Nonferrous Metal , Precious Metal , Silver Alloy , Solder/Braze Alloy

Material Notes:

Silvalloy 45 FC is the lowest melting brazing alloy available composed of silver, copper, zinc, and cadmium. It is suitable for use on most metals except aluminum and magnesium. It is used for joining steel, stainless steel, copper, copper alloys, nickel, nickel alloys or combinations of these metals. It has a wide acceptance by industrial users, as well as being included in Federal military specifications on brazing filler metals or alloys. It has a narrow melting range which is not apparent in most brazing operations, making it flow freely through a capillary. Typical applications are the joining of ferrous, non-ferrous, and dissimilar metals and alloys with close joint clearances. Information provided by Lucas-Milhaupt Warwick, LLC (formerly Wolverine Joining Technologies).

Order this product through the following link:

http://www.lookpolymers.com/polymer_Lucas-Milhaupt-Silvalloy-45-Flux-Coated-Rod-Brazing-Alloy.php

Physical Properties	Metric	English	Comments
Specific Gravity	9.34 g/cc	9.34 g/cc	
Density	9.41 g/cc	0.340 lb/in ³	

Thermal Properties	Metric	English	Comments
Melting Point	607.2 - 618.3 Â°C	1125 - 1145 Â°F	
Solidus	607.2 Â°C	1125 Â°F	
Liquidus	618.3 Â°C	1145 Â°F	

Component Elements Properties	Metric	English	Comments
Cadmium, Cd	13.93 - 15.93 %	13.93 - 15.93 %	
Copper, Cu	4.33 - 14.33 %	4.33 - 14.33 %	As balance of metal
Silver, Ag	27 - 29 %	27 - 29 %	
Zinc, Zn	7.96 - 11.96 %	7.96 - 11.96 %	

Electrical Properties	Metric	English	Comments
Electrical Resistivity	0.00000606 ohm-cm	0.00000606 ohm-cm	

Processing Properties	Metric	English	Comments
Processing Temperature	618.3 - 760 Â°C	1145 - 1400 Â°F	Brazing Temperature

Descriptive Properties	Value	Comments
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Boric Acid % Descriptive Properties	0-30 Value	percentage of flux Comments
Color	Light Yellow	
Colored Pigments %	0-0.05	percentage of flux
Electrical Conductivity (% IACS)	27.6	
Flux	36.78-38.78%	
Potassium Bifluoride %	0-30	percentage of flux
Potassium Fluoroborate %	0-30	percentage of flux
Potassium Pentaborate %	1-5.0	percentage of flux
Potassium Tetraborate %	0-40	percentage of flux
Sodium Dodecyl Sulfate %	0-0.5	percentage of flux

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