

FONTARGEN A 314

Silver brazing alloy, cadmium-free



ISO 17672:	Ag 155
DIN EN 1044:	AG 103
DIN 8513:	L-Ag55Sn
EN ISO 3677:	B-Ag55ZnCuSn-630/660
Material-no.:	2.5159

Composition, typical analysis (% w/w):

Ag	Zn	Cu	Sn
55	22	21	2

Mechanical and physical properties:

Working temperature:	650 °C
Melting range:	630 - 660 °C
Specific gravity:	9.4 g/cm ³
Tensile strength:	330 - 430 N/mm ²
Elongation:	25 %
Electrical conductivity:	7 Sm/mm ²
Hardness:	110 BHN

Characteristics / Applications:

Silver-bearing, cadmium-free low melting brazing alloy, insensitive to overheating for gap and joint brazing of alloyed and unalloyed steel, nickel and nickel alloys, malleable cast iron, copper and copper alloys and carbides. Brazing stainless steel provides the best possible colour match. Suitable for brazing joints which will be used in seawater according to marine code VG 81245, section 3. The absence of cadmium makes it especially suitable for joints destined to come in contact with food. The silicon contained in the brazing alloy can reduce the mechanical property values of welded carbon steels. For brazing joints with a working temperature of max. 200 °C.

Heat sources:

Acetylene torch, air-gas torch, induction and resistance heating

Flux:

F 300 - Series

Approval:

Marine code VG 81245, section 3

Availability:

Bare rods	Coated rods	Wire	Foil	Preforms	Powder	Paste
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