

TECHNICAL SHEET

Ag20Cd

STELLA
WELDING ALLOYS

Product name

Ag20Cd

Class of product

Silver based brazing alloy, cadmium bearing

Corresponding standards

DIN8513	L-Ag20Cd
EN1044	AG 309
AWS A5.8-04	---

Nominal composition (weight %)

Ag:	20
Cu:	40
Zn:	25
Cd:	15

Physical characteristics

Melting range (Solidus – Liquidus):	620 – 750 °C
Brazing temperature:	760 °C
Density:	8,7 g/cm ³
Tensile Strength:	40 kg / mm ²

Range of application:

Ag20Cd is a general purpose, cadmium-bearing, silver brazing alloy, with high melting point and very wide melting range.

It can be used to join ferrous, non ferrous and dissimilar metals and alloys, such as steel, copper, copper alloys.

Due to its very wide melting range, this alloy is mostly used for brazing large and/or not uniform joints.

Brazing procedures include manual, induction, oven techniques.

When brazing in an oxidizing environment a proper flux should be used.

Due to the content of Cadmium special safety precautions must be followed during brazing operations (e.g., avoid of overheating, use of mechanical ventilation, wear of respiratory masks).

Characteristics Make-up:

Rods:	Ø 0,5 ⇔ 4,0 mm	Length: 500 / 1.000 mm
Flux Coated Rods:	Ø 1,5 ⇔ 3,0 mm	
Wires:	Ø 0,25 ⇔ 3,0 mm	(spooled and coiled)
Strips:	Thickness: 0,1 ⇔ 1 mm	Width: 1,5 ⇔ 65 mm
Rings		
Preforms from Wire and from Strip		
Pastes & Powders		

Other dimensions are available upon request

The above data are subject to change without notice by Stella.

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