

TECHNICAL SHEET

Ag30Cd

Product name

Ag30Cd

Class of product

Silver based brazing alloy, cadmium bearing

Corresponding standards

DIN8513	L-Ag30Cd
EN1044	AG 306
AWS A5.8-04	BAG-2a

Nominal composition (weight %)

Ag:	30
Cu:	28
Zn:	21
Cd:	21

Physical characteristics

Melting range (Solidus – Liquidus):	610 – 690 °C
Brazing temperature:	710 °C
Density:	9,1 g/cm ³
Tensile Strength:	38 kg / mm ²

Range of application:

Ag30Cd is a general purpose, cadmium-bearing, silver brazing alloy, with low melting point, extended melting range and good flow properties.

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

Due to its broad melting range, it can be used with good results when joint clearances are not uniform.

Brazing procedures include manual, induction, oven techniques.

The alloy should be heated rapidly through its melting range, in order to prevent possible liquation (separation of the alloy in a low temperature, melting, fluid portion and in a high temperature, melting, solid portion).

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.
