

TECHNICAL SHEET

Cu59ZnAg

STELLA
WELDING ALLOYS

Product name

Cu59ZnAg

Class of product

Copper-Zinc brazing alloy

Corresponding standards

DIN8513 -----
EN1044 -----
AWS A5.8-04 -----

Nominal composition (weight %)

Cu: 59
Zn: Bal
Ag: 1
Mn: < 0,1
Sn: < 0,1
Si: 0,1 – 0,2

Physical characteristics

Melting range (Solidus – Liquidus): 860 – 890 °C
Density: 8,4 g/cm³
Tensile Strength: 45 kg / mm²

Range of application:

Cu59ZnAg is a high-fluidity, good capillarity, brass brazing alloy with 1% silver.

The addition of silver lowers the melting range and increase ductility and electrical conductivity of the alloy.

The use of a proper high-temp flux, as BR1 is necessary.

Brazing techniques range from flame, to induction, to oven.

Because of the high zinc content it is recommended to keep the heating cycle to a minimum to prevent zinc vaporization.

It is used to join steel, cast iron, copper, nickel and nickel alloys.

Recommended for galvanized steels, where its slightly lower melting range, compared to ordinary brasses, helps in protecting the zinc layer.

Typical applications are found in the tubular constructions (metal furniture, bicycle frames, etc.), mining tools, heating and cooling systems, etc.

Characteristics Make-up:

Rods: Ø 1,5 ⇒ 4,0 mm Length: 500 / 1.000 mm
Flux Coated Rods: Ø 1,5 ⇒ 4,0 mm
Wires: Ø 1,5 ⇒ 4,0 mm (spoiled and coiled)
Other dimensions are available upon request

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

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