



Brazelt A-45T (BAg-36)

Nominal Composition:	
Silver	45.00 ± 1.0%
Copper	27.0 ± 1.0%
Zinc	25.0 ± 2.0%
Tin	3.0 ± 0.5 %
Total other Elements	0.15 % Max
Physical Constants:	
Solidus	1195°F (645°C)
Liquidus	1275°F (685°C)
Brazing Range	1310 - 1550°F (710-843°C)
Specific Gravity	8.95
Density (lb/cu in)	4.72
Electrical Conductivity (% IACS)	18.0
Electrical Resistivity (Michroh-m-cm)	9.60
Color	Pale Yellow

DESCRIPTION:

Brazelt A-45T is free flowing, low melting, and an excellent substitute to the cadmium-bearing filler metals with similar silver contents. Brazelt A-45T has a narrow melt range (75° F) that makes it suitable for manual or machine feeding into the braze joint. The alloy is best suited for narrow gap filling in the range of .001” -.005”. Brazelt A-45T is particularly useful in joining steel, copper, copper alloys, and should be used in conjunction with Ultra Flux. The ability to join similar as well as dissimilar metals has allowed for numerous applications in the refrigeration and air conditioning fields.

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength using Brazelt A-45T surpasses the strengths of the base metals. Strength is a function of the base metals being joined, type of joint, design of joint, joint clearances and brazing procedures. The operating temperatures for Brazelt A-45T is up to 400°F (continuous service) and up to 600°F (intermittent service).

APPLICATIONS:

Typical applications are the joining of ferrous, nonferrous, and dissimilar metals and alloys with close joint clearances.

SPECIFICATIONS:

AWS A5-8	BAg-36
ASME	BAg-36

SAFETY INFORMATION:

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, “Safety in Welding and Cutting.” For more complete information refer to the Material Safety Data Sheet for Brazelt A-45T.

AVAILABLE FORMS:

Standard forms of Brazelt A-45T are wire and preforms.