

Brazelt B-72(BAg-8)

Nominal Composition:	
Silver	72.00 ± 1.0%
Copper	Balance
Total other Elements	0.15 % Max
Physical Constants:	
Solidus	1435°F (632°C)
Liquidus	1435°F (688°C)
Brazing Range	1435-1650°F (779-899°C)
Specific Gravity	9.06
Density (lb/cu in)	5.25
Electrical Conductivity (% IACS)	87.0
Electrical Resistivity (Michroh-m-cm)	2.00
Color	White

DESCRIPTION:

Brazelt B-72 is a eutectic composition of the silver-copper system. It is suitable for use in a controlled atmosphere brazing without the use of a paste flux. When molten, Brazelt B-72 is very fluid and may flow out over the work surfaces during some furnace brazing applications. The wetting action on ferrous metals is limited, minimizing its use on carbon steel. Improved wetting observed when furnace brazing of stainless steel with silver-copper filler metals. Most applications for this alloy are on copper and nickel based alloys.

PROPERTIES OF BRAZED JOINTS:

Generally, the joint strength using Brazelt B-72 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 recommended maximum operating temperatures for Brazelt B-72 is up to 400°F (continuous service) and 600°F (intermittent service). Where improved corrosion resistance is needed, nickel may be added to the eutectic composition.

APPLICATIONS:

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

SPECIFICATIONS:

AWS A5-8	BAg-8
ASME	BAg-8

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 B-72.

AVAILABLE FORMS:

Standard forms of Brazelt B-72 are wire, strip and preforms.