

Flux Coated Cadmium Bearing SilverAlloy Cd-50FC

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◆ INTRODUCTION

Aufhauser SilverAlloy Cd-50FC has a narrower melting range than Cd-45FC, making it slightly more free flowing. It is pre-fluxed with the correct amount of flux. No dipping or preparatory work necessary. Cd-50FC is suitable for work in tight spaces. Due to higher silver content, it also has more resistance to corrosion in chlorine, sulfur and steam environments. Cd-50FC may be used where low-temperature, free-flowing filler metals are desired. *This filler metal contains cadmium.*

◆ APPLICATIONS

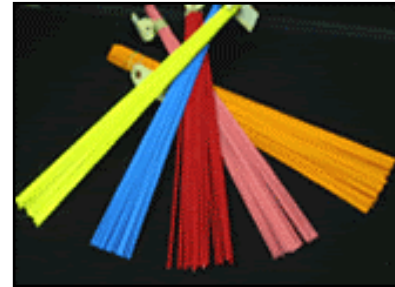
Cd-50FC is used for joining most ferrous and non-ferrous metals. Cd-50FC has good brazing properties and is suitable either for pre-placement in the joint or for manual feeding into the joint. Although lap joints generally are used, butt joints may be used if requirements are less stringent. Joint clearances of 0.001 to 0.005 in. (0.025 to 0.13) are recommended for proper capillary action.

◆ CHEMICAL COMPOSITION

<u>Silver</u>	<u>Copper</u>	<u>Zinc</u>	<u>Cadmium</u>
19.0-51.0	14.5-16.5	14.5-18.5	17.0-19.0

◆ PHYSICAL and MECHANICAL PROPERTIES

Melting Point:	1160 °F
Density:	4.98 TO/Cu.In.
Color, as brazed:	Light Yellow



◆ SPECIFICATIONS MEET or EXCEED

- AWS A5.8 BAg-1a
- AMS 4770G, BAg-1a
- QQ-B-654A, Type IV
- ISO 3677: B Ag 50 Cd Zn Cu 620-640
- BS 1845 AG1
- DIN 8513 LAg 50 Cd
- NFA 81-362, 50 A1

◆ STANDARD SIZES AND DIAMETERS

- Diameters: 1/16", 3/32", 1/8", 5/32", 3/16"
- Sizes: 18", 20", 36" cut lengths

Caution! Contains cadmium. Fumes are poisonous and can kill.

Provide adequate ventilation and do not inhale gases and fumes. Read and understand American National Standard Z49.1, "Safety in Welding and Cutting", available from:

American Welding Society,
550 N.W LeJeune Road, P.O. Box 351040, Miami, Florida 33135.