

Flux Coated Cadmium Free SilverAlloy A-56TFC

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◆ INTRODUCTION

Aufhauser Silver Alloy A-56TFC is a cadmium-free, low melting alloy suitable for use on steel, stainless steel, copper, copper alloys, nickel, nickel alloys or a combination of them. A-56TFC is pre-fluxed with the correct amount of flux. No dipping or preparatory work is necessary. It is suitable for work in tight spaces. Its whitish color provides good color match where necessary.

◆ APPLICATIONS

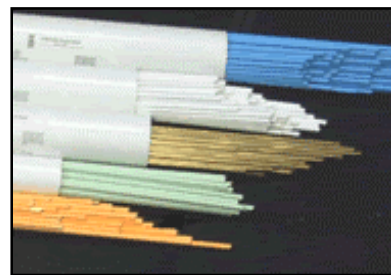
Aufhauser A-56TFC is used for joining most ferrous and non-ferrous metals. A-56TFC has good brazing properties and is suitable either for pre-placement in the joint or for manual feeding into the joint. Although lap joints generally are used, butt joints may be used if requirements are less stringent. Joint clearances of 0.001 to 0.005 in. (0.025 to 0.13) are recommended for proper capillary action. A-56TFC is also used for brazing stainless steel, nickel or nickel alloys where stress cracking occurs during the brazing process.

◆ CHEMICAL COMPOSITION

Silver	Copper	Zinc	Tin
55.0-57.0	21.0-23.0	15.0-19.0	4.5-5.5

◆ PHYSICAL and MECHANICAL PROPERTIES

Solidus:	1145 °F
Liquidus:	1205 °F
Brazing Range:	1205-1400 °F
Specific Gravity:	9.49
Density:	4.96 TO/Cu.In.
Electrical Conductivity:	11.9 %IACS
Electrical Resistivity:	14.5 μohm0cm
Color, as brazed:	White



◆ SPECIFICATIONS MEET or EXCEED

- AWS A5.8 BAg-7
- AMS 4770G, BAg-7
- ASME BAg-7
- QQ-B-654A BAg-7
- ISO 3677: B Ag 56 Cu Zn Sn 620-650
- BS 1845 Ag20
- NFA 81-362, 56 A1

◆ STANDARD SIZES AND DIAMETERS

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

◆ ADDITIONAL INFORMATION

Operating temperature for SilverAlloy A-56TFC is up to 400°F in continuous service and up to 600°F in intermittent service. Where improved corrosion resistance is needed, SilverAlloy Cd-50Ni3 and SilverAlloy A-40Ni2 are recommended over silver base filler metals not containing nickel.