TECHNICAL INFORMATION SHEET

STAY SILV® 45 BRAZING FILLER METAL

CHEMICAL COMPOSITION %:

<table>
<thead>
<tr>
<th>Element</th>
<th>%</th>
</tr>
</thead>
<tbody>
<tr>
<td>Silver</td>
<td>45-46</td>
</tr>
<tr>
<td>Zinc</td>
<td>14-18</td>
</tr>
<tr>
<td>Copper</td>
<td>14-16</td>
</tr>
<tr>
<td>Cadmium</td>
<td>23-25</td>
</tr>
<tr>
<td>Other (Total)</td>
<td>0.15</td>
</tr>
</tbody>
</table>

PHYSICAL PROPERTIES:

- Solidus: 1125°F (605°C)
- Liquidus: 1145°F (615°C)
- Density: 4.96 troy ounces per cu.in.
- Electrical Conductivity: 27.4 IACS

BRAZING PROPERTIES:

This 45% silver alloy is a free flowing filler metal that offers excellent joint strength and ductility. It is typically used to braze steel, and in brazing dissimilar metal connections, such as copper or brass to various steel alloys. It exhibits a narrow melting range so a uniform clearance of 0.002” – 0.005” is recommended.

Stay Silv 45 can be an acceptable choice for applications where sufficient fume ventilation/exhaust equipment is in place to assure operators are not exposed to cadmium oxide fume.

AVAILABLE FORMS

- Standard wire diameters in coils and rod
- Preform rings
- Strip
- Shims/shapes

SPECIFICATION COMPLIANCE:

- ANSI/AWS A5.8 Class BAg-1
- ASME SFA5.8 Class BAg-1
- QQ-B-654A Grade VII

RECOMMENDED FLUX:

Stay-Silv® white flux is suitable for many applications. Stay-Silv® black brazing flux is often used to braze stainless steel or where heating cycles are prolonged or heat is focused as in induction furnace brazing.

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

CONTAINS CADMIUM – FUMES ARE POISONOUS AND CAN KILL – DO NOT BREATH FUMES. EVEN BRIEF EXPOSURE TO HIGH CONCENTRATIONS SHOULD BE AVOIDED.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer’s instructions, Material Safety Data Sheets (MSDS), and your employer’s safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.

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