



SILVER SOLDER AG45

DESCRIPTION

GENERAL PROPERTIES	SILVER SOLDER AG45
Product name:	Stannol Silver Solder AG45
Available sizes:	1,5 / 2,0 / 3,0 mm Ø Length - 500 mm, bare Special formats on request
Norm designation:	DIN EN 1044-AG104 (L-Ag45Sn)
Operating temperature:	670°C
Composition:	45 % Ag, 27 % Cu, 25 % Zn, 3 % Sn
Heat source:	Propane / acetylene torch, oven, HF induction
Flame:	neutral, no excess oxygen or gas
Fields of Application:	Stannol Silver Solder Ag45 is a cadmium-free brazing alloy with a high silver content. It is used for brazing of steel, stainless steel, nickel and nickel alloys as well as copper and copper alloys. It is primarily used in food industries thanks to its excellent corrosion resistance. Other fields of application include refrigeration and cooling units, distillation units, jewellery, and many more.
Note:	Stannol Hard solder paste "Schnellflux", DIN EN 1045-FH10 (type F-SH 1) Silver solder fluxes
Instructions:	Clean all joints (using Stannol cleaning pads or similar), and apply Stannol hard solder paste "Schnellflux" to the pipe end/workpiece. Continuously preheat larger pipe ends/workpieces, until the flux liquefies. Melt the solder against the tip, and use the flame to fill the soldering gap with the molten solder. Please make sure to keep a torch clearance of 10 - 15 mm.

NOTE

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