

AG-20

SPECIAL SILVER ALLOY WITH LOW FUSION POINT AND CAPILLARY FLOW TO JOIN FERROUS AND NON FERROUS METALS

CLASSIFICATION A.W.S: N/C

IDENTIFICATION: BLUE TIP

APPLICATIONS: It is recommended for production and maintenance work with small thicknesses or in delicate jobs with metal that has been submitted to heat treatment. It is suitable for instances when welding with a low fusion point is required together with a good capillary action.

Outstanding results are obtained when joining carbon steel, alloy steel, stainless steel, nickel products and nickel alloys, copper, brass and bronze. Among its main applications are: Welding tungsten carbide bits, welding in sanitary facilities, in the manufacture of different kinds of equipment and in the manufacture of tools. Thanks to its excellent flow properties, absence of pores and a colour that resembles that of brass, it is the ideal alloy to manufacture brass parts like lamps, candle stands, etc

CHARACTERISTICS AND PROCEDURE: Clean the areas to be welded; get rid of oil, grease, rust and paint traces. It is important to bear in mind that if the capillary action is required in this weld, the lap weld is to have a gap between 0.04 mm to 0.08 mm (0.0015" to 0.003").

Coat the area to be welded with S-200 flux as well as the tip of the welding rod. Use a gas torch with a suitable nozzle according to the thickness of the material to be welded. Use a neutral flame. Heat the areas to be welded evenly till the flux melts down.

Place the welding rod tip in position and let the required amount of material to be deposited. Keep on heating till the filler metal evenly covers the areas to be joined. Let the part cool down and later on, get rid of the flux traces.

To restore the copper-like colour in the welded areas, dip the part in a solution of 10 % sulphuric acid and rinse in hot water.

WORKING TEMPERATURE:	750° C a 810° C
SPECIFIC GRAVITY:	8.76 Grs/Cm3
KIND OF FLAME:	NEUTRAL

FILLER METAL CHEMICAL ANALYSIS %				AVAILABLE SIZES
Ag	Cu	Zn	Cd	1.5 mm - 1/16"
20.0	40.0	25.0	15.0	2.4 mm - 3/32"
				3.2 mm - 1/8"