

AG-45

UNIVERSAL TYPE SILVER ALLOY FOR GENERAL PURPOSES. LOW FUSION POINT. TO BE USED WITH FERROUS AND NON FERROUS METALS.

CLASSIFICATION A.W.S: BAg-1

IDENTIFICATION: NAVY BLUE TIP

APPLICATIONS: For fine flow applications in alloy steel, carbon steel, stainless steel, tungsten carbide, copper and copper alloys, nickel and nickel alloys. This product should be used whenever a low fusion point alloy is needed. It is ideal for lap T-welds, to weld flanges and for square butt welds. It is excellent for delicate parts, with small metal thicknesses and for parts which have been submitted to heat treatment. It is to be used with a gas torch, with an oven or with an induction unit.

CHARACTERISTICS: Fine flow silver type alloy. Good corrosion resistance and electrical conductivity. Resulting welds are resistant, ductile and leakproof. It is specially suitable for long butt welds or for large square butt welds. YOU NEED NOT MELT THE BASE METAL WITH THIS WELDING ROD. USE THE LOWEST POSSIBLE HEAT ON THE BASE METAL. It is ideal to weld metals of a different kind together with no distortion risks

PROCEDURE: Parts to be welded together are to be carefully degreased so as to allow the alloy to flow freely. Square butt welds or lap welds should have a 0.04mm - 0.08 mm gap (0.0015" to 0.003"), to attain maximum resistance. Dip the welding rod end in S-200 flux; put some flux on the area to be welded, too. Fix the parts to be welded with clamps if necessary before starting and heat the areas with a neutral flame. Keep the flame cone between 1" to 3" away from the base metal and heat until the flux melts down. Moving the torch from one side to the other all the time, let the torch make the alloy start flowing through the joint. A smooth fillet should result on each side. Let the part cool down and remove the flow traces

TENSILE RESISTANCE:	6,327 Kg/ CM 2 (90,000 PSI)
WORKING TEMPERATURE:	610° C
SPECIFIC GRAVITY:	9.34 Grs/Cm3
ELONGATION:	40 %
KIND OF FLAME:	NEUTRAL

FILLER METAL CHEMICAL ANALYSIS %				AVAILABLE SIZES
Ag	Cu	Zn	Cd	
45.0	15.0	16.0	24.0	1.5 mm - 1/16"
				2.4 mm - 3/32"
				3.2 mm - 1/8"