

FONTARGEN A 319

Silver brazing alloy, cadmium-free



ISO 17672:	Ag 134
DIN EN 1044:	AG 106
DIN 8513:	L-Ag34Sn
EN ISO 3677:	B-Cu36AgZnSn-630/730

Composition, typical analysis (% w/w):

Ag	Cu	Zn	Sn	Si
34	36	27.5	2.5	0.15

Mechanical and physical properties:

Working temperature:	710 °C
Melting range:	630 - 730 °C
Specific gravity:	9 g/cm ³
Tensile strength:	360 - 480 N/mm ²
Elongation:	12 %
Electrical conductivity:	14 Sm/mm ²

Characteristics / Applications:

Cadmium free brazing alloy for gap brazing of alloyed and unalloyed steel, nickel and nickel alloys, malleable cast iron, copper and copper alloys. Suitable for the copper pipe installation according to DVGW work certificate GW 2. The silicon contained in the brazing alloy can reduce the mechanical property values of welded carbon steels. Joint-brazing at working temperatures of -200 °C on austenitic and -70 °C on ferritic steels as well as up until +200 °C.

Heat sources:

Acetylene torch, air-gas torch, induction and resistance heating

Flux:

F 300 - Series

Approval:

DVGW work certificate GW 2

Availability:

Bare rods	Coated rods	Wire	Foil	Preforms	Powder	Paste
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