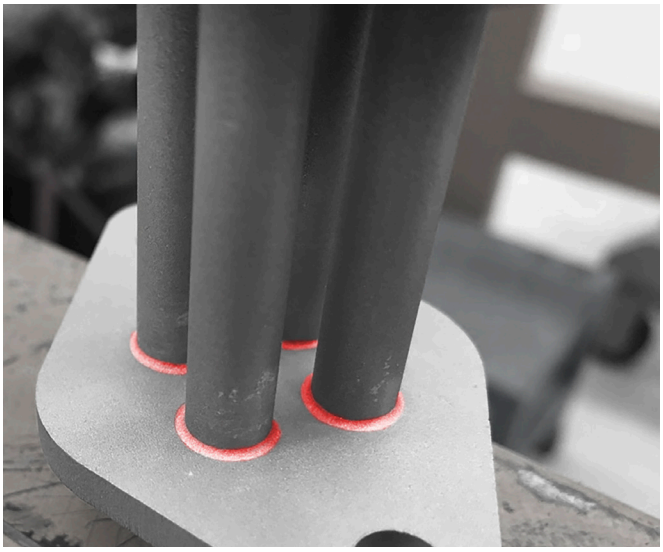
FONTARGEN A 347

Silver brazing alloy, cadmium free

A 347 is a high silver containing alloy with good flow characteristics and high ductility. It is suitable for brazing of stainless steel and copper alloys. A 347 suits to brazing joints operated at temperatures between -200°C/-328°F and +200 °C/+392°F. A 347 offers a good corrosion resistance especially under high temperatures. Best color match while brazing stainless steel. The absence of cadmium makes it especially suitable for joints in the food industry.

Product features	Product benefits	User benefits
» **Low working temperature**	» Low warpage on thin parts	» Time saving process » Interesting temperature window process » No annealing coloring on stainless steel
» **High silver content**	» Lowers down working temperature of the filler metal	» High ductility and tensile strength
» **High service temperature**	» No loss of strength at high temperatures (until 200°C/392°F)	» Possible usage on parts serviced at higher temperature
» **Cadmium free**	» Not hazardous to health	» Can be use in the food industry and drinking water applications » In line with safety tendency
» **Small melting range**	» Good flow properties	» Good capillarity effect. High quality of the joining. » Fast brazing process



Typical applications

» Heat elements
» Plate heat exchangers
» Measuring equipment / devices
» Food industry
» Electrical contacts

Mainly used for

» Parts subject to diverse dynamics forces: (vibrations, dilatation, etc...)
» Parts where no annealing coloring of stainless steel is important
» Parts with high corrosion resistance requirements

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Classification			
AWS A5.8	**EN ISO 17672**	**EN 1044**	**DIN 8513**
BAg-7	Ag156	AG102	L-Ag56Sn

Typical chemical composition, wt. %			
Cu	**Ag**	**Zn**	**Sn**
Bal.	56	17	5

Mechanical properties						
Working Temperature	**Melting Range**	**Specific weight**	**Elongation**	**Operating service temperatures of the joint**	**Max. service temperatures of the joint**	**Electrical conductivity**
650°C/1202°F	620°C/655°C 1148°F/1211°F	9,5 g/cm^3	25%	-200°C/+200°C -328°F/+392°F	200°C/392°F	7 Sm/mm^2

Base materials
Unalloyed and alloyed steel, Nickel alloys, Brass, Bronze, Copper, Iron

Heat sources
Open flame, Induction, Resistance

Flux
FH 10 acc. to EN 1045 => F300 Series of Fontargen

Art. Nr.	Form	Dimensions (mm/inch)	Packaging
32084	Rods	1,5 x 500 / 1/16 x 20	Plastic tubes / 1 lbs
27352	Wire	0,8 / 1/32	S100 spool 156g / 5 TO spool
27351		1,6 / 1/16