

AG-35

SPECIAL SILVER TYPE ALLOY FOR MULTIPURPOSE APPLICATIONS WITH FERROUS AND NON FERROUS METALS. VERY GOOD FLOW PROPERTIES DUE TO ITS CAPILLARITY

CLASSIFICATION A.W.S: BAg-2

IDENTIFICATION: GREEN TIP

APPLICATIONS: For fine flow applications in alloy steel and carbon steel, stainless steel, tungsten carbide, copper and copper alloys, nickel and nickel alloys. It is excellent to restore bronze and brass cast parts, especially to fill in minute pittings. It is ideal to restore tools when it is necessary to weld high speed steel that has been submitted to heat treatment and to retain its hardness at the same time. It is ideal to weld small parts with little or no distortion at all or when welding parts made out of copper and beryllium alloy. It is also suitable to be used in the production of refrigeration equipment since it meets the requirements for leakproof soldering of copper pipes to carry "FREON" gas

CHARACTERISTICS: Silver type alloy, with fine flow. WHEN USING THIS WELDING ALLOY, YOU NEED NOT MELT THE BASE METAL. USE THE LEAST POSSIBLE HEAT ON THE BASE METAL. High corrosion resistance and good electric conductivity. Ideal for joining metals which are different 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:	5,900 Kg/ CM ² (84,000 PSI)
WORKING TEMPERATURE:	650° C
SPECIFIC GRAVITY:	9.29 Grs/Cm ³
ELONGATION:	42 %
KIND OF FLAME:	NEUTRAL

FILLER METAL CHEMICAL ANALYSIS %				AVAILABLE SIZES
Ag	Cu	Zn	Cd	
35.0	26.0	21.0	18.0	1.5 mm - 1/16"
				2.4 mm - 3/32"
				3.2 mm - 1/8"