

GETIG 3911

CD-FREE SILVER BRAZING ROD WITH HIGH TENSILE STRENGTH FOR UNIVERSAL APPLICATIONS.

IDENTIFICATION

Getig 3911,BAg-5

CLASSIFICATION

DIN 8513 : L-Ag 44 ISO 3677 : B Ag 44 CuZn

AWS/SFA 5.8 : BAg-5

DESCRIPTION

Getig 3911 is a high silver containing, Cd-free, brazing rod with very good flowing properties for working temperatures upto 3000C.

It is suitable for brazing joints on steel, stainless steel, nickel and nickel alloys as well as for copper and copper alloys in the food industry (Cd-free) where corrosion resistance is required. The deposit is seawater resistant.

CHEMICAL ANALYSIS (RANGE) %

| Ag | Zn | Cu |
|-------|-------|-------|
| 44-46 | 23-27 | 29-31 |

TYPICAL APPLICATIONS

Applications in the apparatus construction, copper tube installations, food industry and precision tools.

HEAT SOURCES : Acetylene torches.

FLUX : Geebraz 902 Universal silver solder flux in powder form.

INSTRUCTIONS FOR USE

- Clean the soldering zone.
- Apply Geebraz 902 flux.
- Bigger workpieces must be preheated right through over a wide area, until the flux runs like water.
- Place the rod on the joint and melt off a small drop, which is then spread out or drawn along with the flame.

FLAME ADJUSTMENT : Neutral (neither acetylene nor oxygen excess)

PACKING PARAMETERS

| Size (mm) | Length (mm) | Packing / Pkt (kg) | Packing / Box (kg) |
|-------------|-------------|--------------------|--------------------|
| 1.6 | 500 | 2 | 2 x 4 = 8 |
| 2 | 500 | 2 | 2 x 4 = 8 |
| 2.40 / 2.50 | 500 | 2 | 2 x 4 = 8 |
| 3 | 500 | 2 | 2 x 4 = 8 |