

GETIG 9314

CADMIUM-FREE BRAZING FILLER METAL WITH HIGH SILVER CONTENT.

IDENTIFICATION

Getig 9314, Bag-7

CLASSIFICATION

DIN 8513: L-Ag 55 Sn

AWS/ASME/SFA-5.8: B Ag-7

ISO 3677: B Ag 56 Cu Zn Sn 620-650

DESCRIPTION

Brazing filler metal with high silver content, with very good fluidity, suitable for bridging small gaps. Insensitive to overheating.

CHEMICAL ANALYSIS (RANGE) %

Ag	Zn	Sn	Cu
55-57	19.0 min	4.5-5.5	Remainder

TYPICAL APPLICATIONS

- Capillary brazing of steel, stainless steel, malleable cast iron, copper and copper alloys, nickel, hard metal, and also for joints of the above metal amongst themselves.
- The absence of cadmium makes it especially suitable for joints which come in contact with food, e.g. in dairies, breweries etc.
- Brazed joints made with this filler metal on stainless steel give the best possible colour matching.
- Suitable for brazed joints which will operate in seawater.

PHYSICAL PROPERTIES

- **WORKING TEMPERATURE** : 650°C
- **MELTING RANGE** : 620 - 660°C
- **ELECTRICAL CONDUCTIVITY** : 7 Sm/mm²
- **SPECIFIC GRAVITY** : 9.4g/cm³
- **HARDNESS (BRINELL)** : 110 HB

INSTRUCTION FOR USE

Clean the soldering zone. Apply silver brazing flux. Bigger work pieces 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

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.2	500	2	2 x 4= 8
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
3.15 / 3.20	500	2	2 x 4= 8