

Lucas-Milhaupt BRAZE 852 Silver Based Cadmium Free Filler Metal

Category : Metal , Nonferrous Metal , Precious Metal , Silver Alloy , Solder/Braze Alloy

Material Notes:

Characteristics: Braze 852 is a high temperature, free flowing silver brazing filler metal usable both for torch and atmosphere furnace brazing. Due to the high flow point of this alloy, torch brazing is accomplished with Handy Hi-Temp Flux or Handy Hi-Temp Flux Boron Modified. These fluxes may also be required as a supplement when brazing parts in a controlled atmosphere furnace. Even at 2000EF a dew point of -80EF or better is required to reduce manganese oxides in hydrogen. **Applications:** Braze 852 is used principally for applications requiring good strength, at elevated temperatures, in service. This alloy is useful for brazing stainless steels, Stellite and Inconel. It is also effective for brazing certain complex chromium-titanium carbides and is used where carbide tools may encounter high operating temperatures in service. When parts are heat treated subsequent to brazing the high melting point of this alloy is an advantage.

Specifications: This alloy conforms to the following specifications: AMS 4766, AWS A5.8 BAg-23, ASME Boiler and Pressure Vessel Code Section II-C SFA 5.8 BAg-23 Information provided by Lucas-Milhaupt, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Lucas-Milhaupt-BRAZE-852-Silver-Based-Cadmium-Free-Filler-Metal.php

Physical Properties	Metric	English	Comments
Density	9.96 g/cc	0.360 lb/in ³	

Mechanical Properties	Metric	English	Comments
Tensile Strength, Ultimate	41.4 MPa	6000 psi	Type 316 Stainless Steel butt joint
	@Temperature 649 Â°C	@Temperature 1200 Â°F	
	55.2 MPa	8000 psi	Type 316 Stainless Steel sleeve joint
	@Temperature 538 Â°C	@Temperature 1000 Â°F	
	62.1 MPa	9000 psi	SAE 1020 Steel sleeve joint
	@Temperature 649 Â°C	@Temperature 1200 Â°F	
	68.9 MPa	10000 psi	SAE 1020 Steel butt joint
	@Temperature 649 Â°C	@Temperature 1200 Â°F	
	103 MPa	15000 psi	SAE 1020 Steel sleeve joint
	@Temperature 538 Â°C	@Temperature 1000 Â°F	
	138 MPa	20000 psi	SAE 1020 Steel butt joint
	@Temperature 538 Â°C	@Temperature 1000 Â°F	
	145 MPa	21000 psi	

Mechanical Properties	Metric	English	Comments
	159 MPa @Temperature 427 Â°C	23000 psi @Temperature 800 Â°F	SAE 1020 Steel sleeve joint Type 316 Stainless Steel butt joint
	172 MPa @Temperature 649 Â°C	25000 psi @Temperature 1200 Â°F	Type 316 Stainless Steel sleeve joint
	172 MPa @Temperature 22.2 Â°C	25000 psi @Temperature 72.0 Â°F	SAE 1020 Steel sleeve joint
	193 MPa @Temperature 538 Â°C	28000 psi @Temperature 1000 Â°F	Type 316 Stainless Steel butt joint
	276 MPa @Temperature 427 Â°C	40000 psi @Temperature 800 Â°F	SAE 1020 Steel butt joint
	317 - 345 MPa @Temperature 22.2 Â°C	46000 - 50000 psi @Temperature 72.0 Â°F	Type 316 Stainless Steel butt joint
	359 MPa @Temperature 22.2 Â°C	52000 psi @Temperature 72.0 Â°F	SAE 1020 Steel butt joint
	400 MPa @Temperature 316 Â°C	58000 psi @Temperature 600 Â°F	SAE 1020 Steel butt joint
	427 MPa @Temperature 204 Â°C	62000 psi @Temperature 400 Â°F	SAE 1020 Steel butt joint

Thermal Properties	Metric	English	Comments
Melting Point	960 - 971 Â°C	1760 - 1780 Â°F	
Solidus	960 Â°C	1760 Â°F	Melting Point
Liquidus	971 Â°C	1780 Â°F	Flow Point

Component Elements Properties	Metric	English	Comments
Manganese, Mn	>= 13.85 %	>= 13.85 %	
Other, total	<= 0.15 %	<= 0.15 %	

Component Elements Properties	Metric	English	Comments
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Electrical Properties	Metric	English	Comments
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Electrical Resistivity	0.0000375 ohm-cm	0.0000375 ohm-cm	
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Processing Properties	Metric	English	Comments
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Processing Temperature	971 - 1040 Â°C	1780 - 1900 Â°F	Brazing Range
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Descriptive Properties	Value	Comments
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Color	White	
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