

Lucas-Milhaupt Silvacap 35490 Brazing Alloy

Category : Metal , Nonferrous Metal , Copper Alloy , Solder/Braze Alloy

Material Notes:

Silvacap is a low brazing temperature, cadmium-free alloy. It has a slight plastic range which may be noticed during melting on some applications. Generally, the joint strength using Silvacap will surpass the strengths of base metals. Strength is a function of the base metals being joined, type of joint, design of joint, joint clearances and brazing procedures. Typical applications are the joining of copper assemblies with close joint clearances. Information provided by Lucas-Milhaupt Warwick, LLC (formerly Wolverine Joining Technologies).

Order this product through the following link:

http://www.lookpolymers.com/polymer_Lucas-Milhaupt-Silvacap-35490-Brazing-Alloy.php

Thermal Properties	Metric	English	Comments
Melting Point	649 - 700.0 Â°C	1200 - 1292 Â°F	
Solidus	649 Â°C	1200 Â°F	
Liquidus	700.0 Â°C	1292 Â°F	
Maximum Service Temperature, Air	204 Â°C	400 Â°F	continuous
	316 Â°C	600 Â°F	intermittent

Component Elements Properties	Metric	English	Comments
Copper, Cu	85.5 - 87.25 %	85.5 - 87.25 %	As balance
Other, total	<= 0.15 %	<= 0.15 %	
Phosphorous, P	6.25 - 6.75 %	6.25 - 6.75 %	
Silicon, Si	<= 0.10 %	<= 0.10 %	
Tin, Sn	6.5 - 7.5 %	6.5 - 7.5 %	

Processing Properties	Metric	English	Comments
Processing Temperature	677 - 704 Â°C	1250 - 1300 Â°F	Brazing Temperature

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