

Lucas-Milhaupt Silvaloy® 6 Brazing Alloy

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

Material Notes:

Silvaloy 6 is used for the brazing of copper and copper alloys, brass and bronze. It can also be used on silver, tungsten and molybdenum. It should not be used on ferrous and nickel metals or copper alloys containing more than 10% nickel because of phosphorous embrittlement due to reactions with iron and nickel. Applications: The phosphorus content of Silvaloy 6 acts as a fluxing agent and no flux is necessary when brazing copper to copper joints. However, when used with a copper alloy or one of the other brazeable metals, a flux must be used to promote wetting, bonding, and flow throughout the joint. The flow point of Silvaloy 6 is 1325°F. 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-Silvaloy-6-Brazing-Alloy.php

Physical Properties	Metric	English	Comments
Specific Gravity	8.08 g/cc	8.08 g/cc	
Density	8.08 g/cc	0.292 lb/in ³	

Thermal Properties	Metric	English	Comments
Melting Point	643 - 807.2 °C	1190 - 1485 °F	
Solidus	643 °C	1190 °F	
Liquidus	807.2 °C	1485 °F	
Maximum Service Temperature, Air	149 °C	300 °F	continuous
	204 °C	400 °F	intermittent

Component Elements Properties	Metric	English	Comments
Copper, Cu	87.4 - 88.45 %	87.4 - 88.45 %	As balance
Other, total	<= 0.15 %	<= 0.15 %	
Phosphorous, P	5.75 - 6.25 %	5.75 - 6.25 %	
Silver, Ag	5.8 - 6.2 %	5.8 - 6.2 %	

Electrical Properties	Metric	English	Comments
Electrical Resistivity	0.0000196 ohm-cm	0.0000196 ohm-cm	

Processing Properties	Metric	English	Comments
Processing Temperature	718.3 - 816 °C	1325 - 1500 °F	Brazing Temperature

Processing Properties	Metric	English	Comments
Descriptive Properties		Value	Comments
Color		Light Copper	
Electrical Conductivity (% IACS)		8.8	

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