



HILCO SILVER BRAZING RODS

Gas welding rods – non ferrous – silver solders

Silver-Copper-Phosphorus Brazing rods							
Type	Composition				Melting range	Classification	
	Ag	Cu	P	others		AWS A5.8	ISO 17672
L-Ag 2 P	2,0	91,8	6,2	-	645-825°C	~BCuP-6	CuP 279
L-Ag 5 P	5,0	89,0	6,0	-	645-815°C	BCuP-3	CuP 281 ^a
L-Ag 15 P	15,0	80,0	5,0	-	645-800°C	BCuP-5	CuP 284

Cadmium free Silver Brazing Rods							
Type	Composition				Melting range	Classification	
	Ag	Cu	Zn	others		AWS A5.8	ISO 17672
L-Ag 20 Si ¹	20,0	43,9	Bal.	Si: 0,1	690-810°C	-	Ag 220
L-Ag 30 Sn	30,0	36,0	Bal.	Sn: 2,0	665-755°C	-	Ag 130
L-Ag 34 Sn ¹	34,0	36,0	Bal.	Sn: 3,0	630-730°C	~BAg-35	Ag 134
L-Ag 45 Sn ¹	45,0	27,0	Bal.	Sn: 3,0	640-660°C	BAg-36	Ag 145
L-Ag 55 Sn ¹	55,0	21,0	Bal.	Sn: 3,0	630-660°C	~BAg-7	Ag 155

Note:

¹ these Silver Brazing Rods are also available as flux coated rods (FC)