

## XP Ag BRAZE 155 (FLUX COATED)

OXY-FUEL BRAZING



### CLASSIFICATIONS

EN ISO 17672

Ag 155

### KEY FEATURES AND APPLICATIONS

- Ag BRAZE 155 is a cadmium-free, flux coated silver brazing alloy.
- Typically used on ferrous, non-ferrous, and dissimilar alloys for close capillary brazing, such as steel, stainless steel, copper, and nickel-based alloys.
- Offers a low melting point and excellent flow characteristics.
- Flux/paste not required.
- Commonly used in the automotive industry, electronic component, air conditioning, and refrigeration sectors.

### CHEMICAL COMPOSITION OF WIRE %

	Ag	Cu	Zn	Sn
MIN	54.0	20.0	20.0	1.5
MAX	56.0	22.0	24.0	2.5

Single values are maximum values according to EN ISO 17672

### BRAZING TEMPERATURE RANGES

Solidus Melting Temperature	Liquidus Melting Temperature	Recommended Brazing Temperature
630°C	660°C	~670 °C

Temperature ranges are not guaranteed since actual as welded conditions depend on numerous variables

### PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP50630	1.5	500	1	PAP 20 Tube
XP50635	2.0	500	1	PAP 20 Tube

Other sizes available on request