

# Silver Brazing Alloy List

Filler Metal Name	Number of AWS	Nominal Composition (wt%)					Solidus (°C)	Liquidus (°C)	Examples of Main Uses
		Ag	Cu	Zn	Cd	other			
DIA-330	BAG-20	30	38	32			675	765	Overlaying in general use, automobile parts
DIA-435	BAG-5	45	30	25			665	745	Turbine blades, heavy electrical equipment (motor parts)
DIA-530	BAG-6	50	34	16			690	775	Turbine blades, heavy electrical equipment (motor parts)
DIA-520		50	50				780	880	Parts of Automatic controls by atmospheric brazing
DIA-722	BAG-8	72	28				780	780	Electronic components by vacuum brazing
DIA-825	BAG-23	85	15				780	840	Electronic components by vacuum brazing
DIA-345		35	33	30		Sn2	655	740	General use for piping of heat exchanger
DIA-400		40	30	29		Sn1	660	710	Large refrigeration piping, radiators, large heat exchangers
DIA-445		45	25	29		Sn1	665	700	Small brass parts, discharge-pipe of compressors
DIA-487		48	28	19		Sn5	640	690	Brass products
DIA-545	BAG-7	56	22	17		Sn5	620	650	General use such as stainless steel products, parts of automatic controls
DIA-30N		30	34	35		Ni1	686	768	Discharge-pipe of compressor, stainless steel products
DIA-35N		35	31	33		Ni1	680	757	Discharge-pipe of compressor, stainless steel products
DIA-44N	BAG-4	40	30	28		Ni2	670	780	Tungsten carbide tools, stainless steel products
BRAZE 495	BAG-22	49	16	23		Ni4.5 Mn7.5	680	700	Tungsten carbide, stainless steel products in general
BRAZE 505	BAG-24	50	20	28		Ni2	660	705	Stainless steel products in general, brass products
DIA-25		25	30	23	22		595	703	All purpose brazing
DIA-340		30	23	20	27		600	670	All purpose brazing
EASY-FLO 35	BAG-2	35	26	21	18		605	700	All purpose brazing
DIA-440		40	20	14	26		616	665	All purpose brazing
EASY-FLO 45	BAG-1	45	15	16	24		605	620	All purpose brazing
EASY-FLO	BAG-1A	50	16	17	18		625	635	All purpose brazing
EASY-FLO 3	BAG-3	50	16	16	16	Ni3	630	690	Tungsten carbide chips, stainless steel products
DIA-47		47	16	16	16	Ni2 Mn5	630	670	Tungsten carbide chips
DIA-348	BAG-34	38	32	28		Sn2	650	720	Discharge-pipe of compressors
DIAMOND SILVER SOLDER		35	39	23	3		650	790	All purpose brazing