



Argo-braze™ 25DHE – Silver Brazing Filler Metal

Argo-braze™ 25DHE is a cadmium free silver brazing filler metal. It has a long melting range and is useful as a gap filling filler metal producing large fillets. It is, however, prone to liquate (separate into low and high melting constituents) if it is heated slowly through its melting range. For this reason rapid heating methods should be employed wherever possible.

Composition:	25% Ag, 52.5%Cu, 22.5%Zn
Conforms to:	MSRR 9500/ 106 (formerly known as DHE311)
Melting range:	675-855°C

Uses for This Product

This product has been used in aerospace applications and as a surface for bearings and seals in jet engine compressors.

Conditions for Use

This product is designed for brazing in air and should be used in conjunction with a high temperature flux such as Tenacity™ No.5. A rapid heating method such as induction or fixed burner heating is recommended to avoid the problems of liquation.

Product Availability

Manufactured to order only.

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