



Silver-flo™ 24 Silver Brazing Paste

Silver-flo™ 24 brazing paste is a specially formulated paste product intended for use in semi-automated brazing processes or where the use of a paste offers other advantages. It combines Silver-flo™ 24, a comparatively high melting temperature silver brazing filler metal in powder form, with a flux-binder system selected to match an individual application. The resulting product is a fully dispensable custom-made brazing paste.

The use of a brazing paste can improve joint quality by helping to provide repeatability in the amount of filler metal and flux used. Using a brazing paste can lead to productivity improvements and well as enabling pre-placement of the brazing material which can reduce handling and waste.

Silver-flo™ 24 has a melting temperature of 740 to 800°C with a medium length melting range of 60°C providing moderate flow properties when molten. It can be used to fill gaps that cannot be tightly controlled. The optimum joint gap for this filler metal at brazing temperature is normally 0.075 - 0.2mm.

Composition:	24%Ag, 43%Cu, 33%Zn
Conforms to:	Proprietary JM Specification, MSRR 9500/93
Melting range:	740 - 800°C

Uses for this Product

This filler metal has been incorporated into aviation / aero industry standards and is consequently used in the manufacture of components for applications in this field. It is also used as the first alloy in a two-step silver brazing operation, where the second joint is made with Silver-flo™ 55.

Silver-flo™ 24 can be used to join all the common engineering materials (excluding aluminium) such as copper, copper alloys (including, brasses, bronzes, gun metal, nickel silvers, aluminium bronze, copper nickel), steels including, mild, carbon, tool steel, stainless steels, low alloy steel). This alloy is not normally recommended for brazing tungsten carbide and PCD segments, where Argo-braze™ silver brazing filler metals are often preferred.

Conditions for Use

Further details on how to use a brazing paste can be found at www.jm-metaljoining.com. Select the 'Technical' section and then follow the 'Brazing techniques' link.

Silver-flo™ 24 brazing paste should be pre-placed on the outside of the component and not trapped between components or 'sandwiched' in the joint. Brazing paste should be heated indirectly using the heat build up in the components to cause it to melt. Flux residues should be removed by soaking and then washing in warm water.

Product Availability

Brazing pastes are made to order

Grades of paste currently in use (this datasheet applies to all grades of Silver-flo™ 24 brazing paste)

180-B1-75, 180-B1-65

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Johnson Matthey

Metal Joining York Way, Royston, Hertfordshire, SG8 5HJ, UK

Telephone: +44 (0) 1763 253200

Fax: +44 (0) 1763 253168

email: mj@matthey.com

www.jm-metaljoining.com