

S-Sn97AG3

CATEGORY	Brazing
TYPE	3% silver containing cadmium free soft solder alloy
APPLICATIONS	Soldering applications in cooling, automotive and electronic industry. Suitable for food applications due to the absence of Cadmium. Suitable for working temperatures up to 100°C.
PROPERTIES	Used for strong brazing joints of uneven junctions with excellent flowing properties. Offers much better mechanical characteristics compare to standard PbSn soft solders. Excellent results are obtained on stainless steel with our "ST" flux.
CLASSIFICATION	EN ISO 9453: S-Sn97Ag3

SUITABLE FOR Steel, stainless steel, brass, copper, galvanised steels, Sn plated steels etc.

APPROVALS CE approved, RoHS

WELDING POSITIONS:



FILLER METAL ANALYSIS %

Ag	Sn
2,7-3,5	Rem

MECHANICAL PROPERTIES

Conductivity (m/Ωmm ²)	Rm at 100°C (N/mm ²)	Rm at 20°C (N/mm ²)	Weight (g/cm ³)	brazing range (°C)	Impact Energy (J) ISO-V -40°C -60°C	Melting point (°C)
7,5	17*	27*	7,5	280-350		221-224

* shear strength

BRAZING PARAMETERS / PACKING

Wire sizes	Packing	Heating	Optimum brazing
D (mm)	kg / spools	system	Gab
1,6	0,25 / 1,0 / 5,0	Flame / Induction / oven	0.10 - 0.30 mm
2.4	0,25 / 1,0 / 5,0	Flame / Induction / oven	0.10 - 0.30 mm
3.2	0,25 / 1,0 / 5,0	Flame / Induction / oven	0.10 - 0.30 mm

REDRYING TEMPERATURE not required

OTHER DELIVERY FORMS Customized rings for brazing