

Specifications:

AWS A5.8
 AWS BAg-24
 AMS 4788
 Silver Alloy 50Ni2
 UNS P07505

Properties:

Brazing Temperature Range High: 1405°F / 763°C
Brazing Temperature Range Low: 1355°F / 735°C
Liquidus: 1305°F / 707°C
Solidus: 1220°F / 660°C

Description:

WT 50Ni2, BAg-24, is widely used to wet nickel and iron based alloys. It is very fluid at its low flow point, which the low flow point minimizes oxidation during brazing of stainless steel. It has the capability to quickly fill long/narrow joints. It is frequently used to join 300 stainless steel and in most exposures where the base metals are suitable can stop interface corrosion. With the nickel, 50Ni2 can be used in the joining of tungsten carbide inserts. Due to the alloy being cadmium free this can be used on food handling industry. This alloy should be heated quickly through the melting range because it has a tendency to have a separation of low and high melting constituents.

Chemical Composition:

Ag	Cu	Zn	Ni
50%	20%	28%	2%

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.