

<u>Specifications:</u>	<u>Properties:</u>	<u>Properties (cont.):</u>
AWS A5.8/A5.8M BAg-13 AMS 4772 UNS P07540	Brazing Temperature Range: 1625-1675°F / 885-912°C Color: White Liquidus: 1575°F / 857°C Solidus: 1325°F / 718°C	Electrical Conductivity (%IACS): 49.8 Specific Gravity: 9.63 Electrical Resistivity (Microhm-cm): 3.46 Density (Troy oz/in³): 5.07

Description:

WT 54 is a silver brazing alloy that has a long melting range (235°F), which is useful when wide gap joints are hand fed since semi-fluid alloys can be working across the gaps. Through the melting range, if heated slowly, it has a tendency to liquate. So it is preferable to use where assembly can be heated rapidly to brazing temperature. Flux is recommended. WT 54 is often used in furnace brazing because of its low zinc content. It is often used for making joints that are subjected to elevated temperatures, up to 700°F. Stainless steel butt joints furnace brazed with WT 54 can develop room temperature tensile strengths of 50,000-60,000 PSI with commercial joint clearances.

Chemical Composition:

Ag	Cu	Zn	Ni	OET
54% (±1.0)	40% (±1.0)	5% (±2.0)	1% (±0.5)	0.15% Max

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.