

GENERAL INFORMATION
General information

Production process	Soldering and brazing
Color	Silver
Typology	Master alloy for silver

Melting temperatures

Liquidus [°C]	695.0
Solidus [°C]	675.0
Melting range [°C]	20.0

Working temperatures

Minimum working temperature [°C]	685.0
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Commercial composition

Copper (%)	55,00
Zinc (%)	45,00



SILVER line

FULL CHARACTERIZATION DATA
Color coordinates

L*	87.3
a*	-0.6
b*	13.2

Physical characteristics

Density [g/cm ³]	9.5
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Mechanical characteristics

As cast hardness [HV 0.2]	145.0
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MECHANICAL WORKING PARAMETERS

Pre-mixing temperature [°C] 815.0

Reductions

Sheet - area or thickness (%)	60.0
Wire - diameter (%)	40.0

POURING TEMPERATURES

Countinous from [°C]

Countinous to [°C]

Ingot from [°C]

Ingot to [°C]

Temperatures

795.0

875.0

775.0

815.0

MECHANICAL WORKING ANNEALING

Temp. from [°C]

Temp. to [°C]

Time [min]

<1 mm

500.0

520.0

15.0

1 - 5 mm

500.0

520.0

20.0

>5 mm

500.0

520.0

25.0

Mechanical working quenching

Quench directly in a 50% water/50% alcohol solution or in water

PRODUCT TECHNICAL GUIDELINES**Preliminary checks**

Please note that in order to correctly evaluate the alloy's hardness to solderability, it is advised to make a numerical calculation by subtracting the base metal solidus temperature value from the solder liquidus temperature value. The higher the number resulting, the more solderable (or the less hard) the alloy can be considered. Please refer to the technical guideline for solders available in the website for further information.

Notes on alloy title

SOFT SOLDER: LSA440 35% + Ag 65%.

MEDIUM SOLDER: LSA440 25% + Ag 75%.

HARD SOLDER: LSA440 15% + Ag 85%.

The information contained in the technical datasheet refer to a solder containing 65% silver.