



宝鸡难熔金属开发公司

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SOLDER

✧ Properties of the products:

- Low melting point
- Characteristic of well wettability
- Good ability to fill the gap
- Good intensity and toughness
- Good electric conductivity and corrosion resistance

Solder alloy No.	Solidus line	Liquidus	Characteristic
Au	1064.43	1064.43	Wetting of tungsten, used in low temperature diffusion bonding
AuNiCu3-15.5	1000	1030	Good Fluidity.Excellent wettability of copper, nickel and steel
AuCuIn77-3	975	1025	Nature is similar to AuCu65
AuCu65	990	1010	Brazing of copper, nickel, Kovar alloy
AuCu62	985	1005	Brazing of copper, nickel, Kovar alloy
AuCu60	980	1000	Brazing of copper, nickel, Kovar alloy
AuCu50	955	970	Brazing of copper, nickel, Kovar alloy
AuNi18	950	950	Has good wettability of tungsten, molybdenum, copper, nickel, stainless steel. Good fluidity, vapor pressure, high temperature strength
AuCu20	908	910	Slow cooling molten state be brittle, generally with a 9th-alloy
AuAgCu5-20	885	895	As a second-level soldering parts, generally higher melting point of brazing alloys of 2nd or 3rd
AuAgCu20-20	835	845	Melting temperature with a very narrow scope for meso-level soldering

❖ **Chemical Composition:**

Solder alloy No.	Chemistry (%)						Melting Temperature °C	Used
	Ag	Cu	Cd	Ni	Mn	Zn		
AgCu53-37	10±0.3	53±1	—	—	—	Balance	810~850	Brazing of parts made of copper and other nonferrous metals, copper or high brazing of titanium carbide
AgCu40-35	25±0.3	40±1	—	—	—	Balance	745~775	Braze welding requires smooth and in shock and vibration strength of copper, copper alloys, steel parts
AgCu30-25	45±0.5	30±1	—	—	—	Balance	660~725	Braze welding requires smooth and in shock and vibration strength of copper, copper alloys, steel parts
AgCu34-16	50±0.5	34±1	—	—	—	Balance	690~775	Brazing is able to withstand repeated vibratory loads of artifacts, such as band saws
AgCu20-15	65±0.5	20±0.5	—	—	—	Balance	685~720	Commonly used for brazed saw blade, small parts and food appliances
AgCu26-4	70±0.5	26±1	—	—	—	Balance	720~755	Applies to copper, brass and silver brazing, commonly used in brazing wires and high conductive components
AgCu28	72±0.5	28±1	—	—	—	Balance	779	Used for braze welding of tubes and other vacuum devices
AgCu27-18-8-3-2	44±1	27±1	8±1	2±0.5	3±0.5	16.6~18.8	650~800	Applies to brazing copper, brass and stainless steel workpieces
AgCd26-17-17	40±1	16.7 ^{+0.7} -0.3	25~26.5	0.3±0.2	—	17+0.8-0.4	595~605	Brazing of hardened steel, can make parts maintain original performance, used for soldering small thin pieces, control deformation
AgCd18-16-16	50±1	16±0.5	18±1	—	—	16±1	625~635	Similar application with above, but its high strength

❖ Products show:

