

Flux Coated Cadmium Bearing SilverAlloy Cd-35 FC

◆ INTRODUCTION

Aufhauser Cd-35FC is a modification of SilverAlloy Cd-45FC to combine reasonable good brazing properties and lower silver content at the expense of slight elevated temperature (150°F). It has a broader melting range than Cd-45FC, which is helpful where clearances are wide or not uniform. Unless heating is rapid, care must be taken that the lower melting constituents do not separate out by liquidation. Cd-35FC is free-flowing and suited for general purpose work. Aufhauser SilverAlloy Cd-35FC is pre-fluxed with the correct amount of flux. No dipping or preparatory work. It is suitable for work in tight spaces. *This filler metal contains cadmium.*

◆ APPLICATIONS

Aufhauser Cd-35FC is used for joining most ferrous and non-ferrous metals. Cd-35FC has good brazing properties and is suitable either for pre-placement in the joint or for manual feeding into the joint. Although lap joints generally are used, butt joints may be used if requirements are less stringent. Joint clearances of 0.001 to 0.005 in. (0.025 to 0.127 mm) are recommended for proper capillary action.

◆ CHEMICAL COMPOSITION

<u>Silver</u>	<u>Copper</u>	<u>Zinc</u>	<u>Cadmium</u>
34.0-36.0	25.0-27.0	19.0-23.0	17.0-19.0



◆ PHYSICAL and MECHANICAL PROPERTIES

Melting Point:	1125 °F
Flow Point:	1295 °F
Specific Gravity:	9.18
Density:	4.84 TO/Cu.in.
Electrical Conductivity:	28.5 %IACS
Electrical Resistivity:	6.02 Microhm-cm
Color, as brazed:	Light Yellow

◆ SPECIFICATIONS MEET or EXCEED

- AWS A5.8 BAg-2
- AMS 4768D, Class BAg-2
- QQ-B-654A, Type VIII
- ISO 3677: B Ag 35 Cd Zn Cu 610-700
- NFA 81-362, 35 A1

◆ STANDARD SIZES AND DIAMETERS

- Diameters: 1/16", 3/32", 1/8", 5/32", 3/16"
- Sizes: 18", 20", 36" cut lengths

Caution! Contains cadmium. Fumes are poisonous and can kill.

Provide adequate ventilation and do not inhale gases and fumes. Read and understand American National Standard Z49.1, "Safety in Welding and Cutting", available from:

American Welding Society,
550 N.W LeJeune Road, P.O. Box 351040, Miami, Florida 33135.