

Flux Coated Cadmium Bearing SilverAlloy Cd-45FC

◆ INTRODUCTION

Aufhauser SilverAlloy Cd-45FC possesses the lowest brazing temperature of the BAg filler metals, allowing it to flow most freely into narrow clearance capillary joints. Cd-45FC is pre-fluxed with correct amount of flux. No dipping or preparatory work. Suitable for work in tight spaces. Its narrow melting range is suitable for rapid or slow methods of heating. *This filler metal contains cadmium.*

◆ APPLICATIONS

Aufhauser Cd-45FC is used for joining most ferrous and non-ferrous metals except aluminum and magnesium. Cd-45FC 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

Silver	Copper	Zinc	Cadmium
44.0-46.0	14.0-16.0	14.0-18.0	23.0-25.0



◆ PHYSICAL and MECHANICAL PROPERTIES

Melting Point:	1125 °F
Flow Point:	1145 °F
Specific Gravity:	9.42
Density:	4.96 TO/Cu.In.
Electrical Conductivity:	27.6 %IACS
Electrical Resistivity:	6.06 Microhm-cm
Color, as brazed:	Light Yellow

◆ SPECIFICATIONS MEET or EXCEED

- AWS A5.8 BAg-1
- AMS 4769B, Class BAg-1
- QQ-B-654A, Type VII
- ISO 3677: B Ag 45 Cd Zn Cu 620-635
- DIN 8513 LAg 45 Cd
- NFA 81-362, 45 A1

◆ STANDARD SIZES AND DIAMETERS

- Diameters: 1/16", 3/32", 1/8", 5/32", 3/16"
- Sizes: 18" 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.