

EASY-FLO[®] 25 **(SILVALOY[®] 25)**

NOMINAL COMPOSITION

Silver	25.0% ± 1.0%
Copper	35.0% ± 1.0%
Zinc	26.5% ± 2.0%
Cadmium	13.5% ± 1.0%
Other Elements (Total)	0.15% Max

PHYSICAL PROPERTIES

Color	Light Yellow
Melting Point (Solidus)	1125°F (605°C)
Flow Point (Liquidus)	1375°F (745°C)
Brazing Temperature Range	1375°F -1575°F (745°C - 855°C)
Specific Gravity	8.65
Density (Troy oz/in ³)	4.56
Electrical Conductivity (% IACS) ⁽¹⁾	29.7
Electrical Resistivity (Microhm-cm)	5.70

⁽¹⁾ IACS = International Annealed Copper Standard

PRODUCT USES

Easy-Flo 25 is an economical, general purpose braze filler metal for joining ferrous and non-ferrous materials where relatively large clearances are encountered.

BRAZING CHARACTERISTICS

Easy-Flo 25 exhibits good wetting characteristics on steels, cast irons and copper alloys. The wide melting range of this filler metal results in good filling of wide gap joints. Fast heating through the melt zone is recommended to prevent liquation.

PROPERTIES OF BRAZED JOINTS

The properties of a brazed joint are dependent upon numerous factors including base metal properties, joint design, metallurgical interaction between the base metal and the filler metal. Butt joints of the listed metals have been tested at room temperature with the following typical results:

	Tensile Strength (lbs/in ²)	Elongation (% in 2 in.)
SAE 1020 Steel	58,000	10.0
304 Stainless Steel	72,000	10.0

AVAILABLE FORMS

Wire.

SPECIFICATIONS

Easy-Flo 25 alloy conforms to the following specifications:

- American Welding Society (AWS) A5.8/A5.8M BAg-27
- ASME Boiler & Pressure Vessel Code, Sec II-C, SFA-5.8 BAg-27

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: A00000061, Legacy Codes: 31-250, 26815

SAFETY INFORMATION

Easy-Flo 25 contains cadmium. Cadmium fumes are poisonous. This alloy should be used only in well-ventilated spaces with air movement which will carry brazing fumes away from the worker's face. Refer to ANSI Z49.1 entitled "Safety in Welding and Cutting", and the Lucas-Milhaupt Material Safety Data Sheet for detailed information.

WARRANTY CLAUSE

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