

EASY-FLO[®] 44 **(BRAZE[™] 440, SILVALOY[®] 44)**

NOMINAL COMPOSITION

Silver	44.0% ± 1.0%
Copper	27.0% ± 1.0%
Zinc	13.0% ± 2.0%
Cadmium	15.0% ± 1.0%
Phosphorus	1.0% ± 0.2%
Other Elements (Total)	0.15% Max

PHYSICAL PROPERTIES

Color	Light Yellow
Melting Point (Solidus)	1100°F (593°C)
Flow Point (Liquidus)	1370°F (743°C)
Brazing Temperature Range	1220°F - 1400°F (660°C - 760°C)
Specific Gravity	8.83
Density (Troy oz/in ³)	4.65
Electrical Conductivity (%IACS) ⁽¹⁾	13.8
Electrical Resistivity (Microhm-cm)	12.5

⁽¹⁾ IACS = International Annealed Copper Standard

PRODUCT USES

Easy-Flo 44 is used in applications requiring a low melting, free flowing filler metal with good wetting characteristics. Typical uses include brazing of silver-cadmium-oxide and silver-graphite contacts in addition to molybdenum, and copper-tungsten electrode assemblies.

BRAZING CHARACTERISTICS

Easy-Flo 44 is a low melting, free flowing filler metal. It exhibits good wetting and flow characteristics on molybdenum and cadmium oxide type contact materials.

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.

AVAILABLE FORMS

Strip, engineered preforms, specialty preforms per customer specification.

SPECIFICATIONS

Easy-Flo 44 alloy conforms to the following specifications: N/A

Technical Data Sheet

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: A00000033, Legacy Codes: 32-440, 10736.

SAFETY INFORMATION

Easy-Flo 44 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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