

Silver Brazing Alloy J491MN

Composition (wt %)									ISO 17672	AWS
Ag	Cu	Zn	Mn	Ni	Sn	Si	P	Other		
49	27,5	20,5	2,5	0,5	-	-	-	-	-	-

Technical data

Density	8,9 g/cm ³
Melting range	670-690 °C
Shear strength	-
Tensile strength	-
Recommended joint gap	0,1-0,25 mm
Maximum operating temperature of brazed joint	200 °C

Applications

This alloy is especially suitable for brazing tools, cemented carbides and materials with low wettability (such as tungsten, tantalum, molybdenum, chromium, etc.), providing a joint with good mechanical properties. However, joint strength depends on various factors: type of base metals to be joined, type of joint, joint gap, etc.

J491MN may reduce corrosion at the interface when employed to join stainless steels.

The melting range of this alloy is quite narrow.

Heat sources commonly employed are flame or induction heating system.

Standard forms and dimensions

Product	Feasibility
Wire	✓
Strip	✓
Rods	✓
Flux coated rods	-
Rings	✓

Recommended fluxes

Special FPA, Universal FPA, General FPO.

Note

Silver brazing alloys and dimensions other than those listed in our catalogue are available upon request.

Details included in this technical data sheets are based on our knowledge and experience and are believed to be accurate. All data in this data sheet are merely recommendations and shall not be regarded as an assurance of any properties of the product. *We do not assume any responsibility and make no warranty with respect to the results that may be obtained and the damages that may occur from the use of the information provided.*

Since end use of the product is not under our direct control, it is the user's responsibility to comply with applicable safety and hygiene laws and regulations.