

Meta-Braze™ 440

Silver Copper Braze Alloy

Meta-braze™440 is a silver copper zinc braze alloy containing a small amount of nickel to enhance wetting on carbide. It has sluggish flow properties and so produces large fillets. It is used primarily for brazing tungsten carbide to steel and is suitable for large gaps. It is also used to join stainless steel, mild steel and cast iron as well as copper and nickel alloys. Due to the long melting range it is advised to heat rapidly through the melting range to prevent liquation. Typical applications include: Carbide cutting tools and food and medical stainless-steel products.

Standard	ISO 17672:2016 Ag 440	Reference Standard AWS A5.8 Bag-4								
Melting Range	670°C - 780°C	Brazing Temperature: 790°C								
Chemical Composition	<table border="0"> <tr> <td>Silver</td> <td>40%</td> </tr> <tr> <td>Copper</td> <td>30%</td> </tr> <tr> <td>Zinc</td> <td>28%</td> </tr> <tr> <td>Nickel</td> <td>2%</td> </tr> </table> <p>Impurities as per ISO 17672 Table 1</p>	Silver	40%	Copper	30%	Zinc	28%	Nickel	2%	
Silver	40%									
Copper	30%									
Zinc	28%									
Nickel	2%									
Conditions for Use	<p>Recommended Processes: Flame or Induction. Recommended Gap Size: 0.1 – 0.25mm (0.004 – 0.010") Recommended Flux: Meta-braze™ LT 025 Flux Powder</p>									
Physical Properties	<p>Density – 8.9 g/cm³ Tensile Strength – 350 MPa</p>									
Forms of Supply	Foil – Wire – Powder – Paste – Preforms									

