

## **EASY-FLO<sup>®</sup> 44** **(BRAZE<sup>™</sup> 440, SILVALOY<sup>®</sup> 44)**

### ***NOMINAL COMPOSITION***

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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***

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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 <sup>3</sup> )	4.65
Electrical Conductivity (%IACS) <sup>(1)</sup>	13.8
Electrical Resistivity (Microhm-cm)	12.5

<sup>(1)</sup> IACS = International Annealed Copper Standard

### ***PRODUCT USES***

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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***

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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***

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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***

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Wire, strip, engineered preforms, specialty preforms per customer specification, powder and paste.

### ***SPECIFICATIONS***

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

## ***APPLICABLE PRODUCT CODE(S)***

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

## ***SAFETY INFORMATION***

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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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