

# Standard Industrial Brazing Alloys

AWS A5.8-76 Classification	Alloy Composition %									Solidus Temp.		Liquidus Temp.	
	Ag	Cu	Zn	Cd	Ni	Sn	Au	Li	P	°F	°C	°F	°C
<b>General Silver Brazing Alloys that include Cadmium (Flux is required)</b>													
B <sub>Ag</sub> 1	45	15	16	24	–	–	–	–	–	1,125	607	1,145	619
B <sub>Ag</sub> 1a	50	15.5	16.5	18	–	–	–	–	–	1,160	627	1,175	619
B <sub>Ag</sub> 2	35	26	21	18	–	–	–	–	–	1,125	670	1,310	710
B <sub>Ag</sub> 2a	30	27	23	20	–	–	–	–	–	1,125	670	1,310	710
B <sub>Ag</sub> 3	50	15.5	15.5	16	3	–	–	–	–	1,170	632	1,270	680
<b>Cadmium Free General Silver Brazing Alloys (Flux is required)</b>													
B <sub>Ag</sub> 4	40	30	28	–	2	–	–	–	–	1,220	660	1,292	700
B <sub>Ag</sub> 5	45	30	25	–	–	–	–	–	–	1,250	677	1,370	743
B <sub>Ag</sub> 6	50	34	16	–	–	–	–	–	–	1,270	688	1,425	774
B <sub>Ag</sub> 7	56	22	17	–	–	5	–	–	–	1,145	619	1,205	651
B <sub>Ag</sub> 8	72	28	–	–	–	–	–	–	–	1,435	779	1,435	779
B <sub>Ag</sub> 8a	71.8	28	–	–	–	–	–	0.2	–	1,400	760	1,400	780
B <sub>Ag</sub> 9	65	20	15	–	–	–	–	–	–	1,280	593	1,325	718
B <sub>Ag</sub> 10	70	20	10	–	–	–	–	–	–	1,275	691	1,360	738
B <sub>Ag</sub> 13	54	40	5	–	1	–	–	–	–	1,325	718	1,572	857
B <sub>Ag</sub> 13a	56	42	–	–	2	–	–	–	–	1,420	771	1,640	893
B <sub>Ag</sub> 18	60	30	–	–	–	10	–	–	–	1,115	602	1,325	718
B <sub>Ag</sub> 19	92.5	7.3	–	–	–	–	–	0.2	–	1,400	760	1,635	890
B <sub>Ag</sub> 20	30	38	32	–	–	–	–	–	–	1,250	677	1,410	766
B <sub>Ag</sub> 21	63	28.5	–	–	2.5	6	–	–	–	1,275	690	1,474	700
B <sub>Ag</sub> 24	50	20	28	–	2	–	–	–	–	1,220	660	1,305	707
B <sub>Ag</sub> 28	40	30	28	–	–	2	–	–	–	1,202	650	1,205	651
B <sub>Ag</sub> 34	38	32	28	–	–	2	–	–	–	1,200	648	1,330	720
B <sub>Ag</sub> 35	35	32	33	–	–	–	–	–	–	1,265	684	1,390	754
B <sub>Ag</sub> 36	45	27	25	–	3	–	–	–	–	1,195	643	1,251	677
B <sub>Ag</sub> 37	25	41	32	–	–	2	–	–	–	1,265	685	1,400	760
<b>Brazing Alloys for Fluxless Brazing of Copper and Rich Copper Alloys</b>													
BCuP-1	–	95	–	–	–	–	–	–	5	1,310	710	1,650	899
BCuP-2	–	92	–	–	–	–	–	–	7.25	1,310	710	1,460	793
BCuP-3	5	89	–	–	–	–	–	–	6	1,190	644	1,450	788
BCuP-4	6	86.75	–	–	–	–	–	–	7.25	1,190	644	1,335	724
BCuP-5	15	80	–	–	–	–	–	–	5	1,190	644	1,475	802
BCuP-6	2	90.8	–	–	–	–	–	–	7.25	1,190	644	1,450	788
Zero-6™	<b>Proprietary Alloy</b>			•	•	•	•	•	•	1,235	668	1,390	755
<b>Gold Brazing Alloys (Flux is required)</b>													
BAu 1	–	62.5	–	–	–	–	37.5	–	–	1,815	990	1,860	1,015
BAu 3	–	62	–	–	3	–	35	–	–	1,785	937	1,885	1,028
BAu 4	–	–	–	–	18	–	82	–	–	1,742	950	1,742	950

Zero-6 is a proprietary alloy - Contact Altem

Ag = Silver

Ni = Nickel

Zn = Zinc

Cd = Cadmium

Cu = Copper

Sn = Tin

P = Phosphorus

Au = Gold

Li = Lithium

ASW = American Welding Society, a standards setting organization in the United States