LucasMilhaupt®
A Handy & Harman Company
Global Brazing Solutions®

Technical Data Sheet

SILVALOY® 560
(BRAZE ™ 560, SILVALOY A56T)

NOMINAL COMPOSITION

Silver	56.0% ± 1.0%
Copper	22.0% ± 1.0%
Zinc	17.0% ± 2.0%
Tin	5.0% ± 0.5%
Other Elements (Total)	0.15% Max

PHYSICAL PROPERTIES

Color	White
Melting Point (Solidus)	1145°F (620°C)
Flow Point (Liquidus)	1205°F (650°C)
Brazing Temperature Range	1205°F - 1400°F (650°C - 760°C)
Specific Gravity	9.42
Density (Troy oz/in^3)	4.96
Electrical Conductivity (%IACS) [(1)]	8.32
Electrical Resistivity (Microhm-cm)	20.8

[(1)] IACS = International Annealed Copper Standard

PRODUCT USES

Silvaloy 560 is a silver-based brazing alloy used for ferrous and non-ferrous alloys in joints requiring a low temperature, cadmium-free alloy, as in food handling equipment. For improved corrosion resistance in joints on stainless steel, use alloys containing small amounts of nickel, such as Silvaloy 630 or Silvaloy 505.

BRAZING CHARACTERISTICS

Silvaloy 560 is a low temperature, free-flowing brazing filler metal with a slight tendency to liquate (i.e. separate into low and high melting constituents) if heated slowly through its melting range.

PROPERTIES OF SILVALOYD 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.

	Tensile Strength (lbs/in^2)
Low Carbon Steel	40,000 - 50,000
Copper	25,000 - 30,000
Brass	30,000 - 40,000

Lucas-Milhaupt, Inc. • 5656 S. Pennsylvania Ave • Cudahy, WI 53110 • Phone: 414.769.6000 • Fax: 414.769.1093 • www.lucasmilhaupt.com

AVAILABLE FORMS

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

SPECIFICATIONS

Silvaloy 560 alloy conforms to the following specifications:

- American Welding Society (AWS) A5.8/A5.8M BAg-7
- ASME Boiler & Pressure Vessel Code, Sec II-C, SFA-5.8 BAg-7
- Society of Automotive Engineers (SAE) / AMS 4763

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 32-560, 3558, 35554.

Distribution P/N: 98060, 98061, 98062, 98064, 98065, 98066, 98067.

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Material Safety Data Sheet for Silvaloy 560.

WARRANTY CLAUSE

Lucas-Milhaupt, Inc. believes the information contained herein to be reliable. However, the information is given by Lucas-Milhaupt, Inc. without charge and the user shall use such information at its own discretion and risk. This information is provided on an "AS IS" AND "AS AVAILABLE" basis and Lucas-Milhaupt, Inc. specifically disclaims warranties of any kind, either express or implied, including, but not limited to, warranties of title or implied warranties of merchantability or fitness for a particular purpose. No oral advice or written or electronically delivered information given by Lucas-Milhaupt, Inc. or any of its officers, directors, employees, or agents shall create any warranty. Lucas-Milhaupt, Inc. assumes no responsibility for results obtained or damages incurred from the use of such information in whole or in part.

Lucas-Milhaupt, Inc. • 5656 S. Pennsylvania Ave • Cudahy, WI 53110 • Phone: 414.769.6000 • Fax: 414.769.1093 • www.lucasmilhaupt.com