

AERONAUTICAL MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
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New York City

AMS 4770B

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BRAZING ALLOY, SILVER
50Ag - 18Cd - 16.5Zn - 15.5Cu

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. FORM: Wire, strip, pig, granular, or as ordered.
3. APPLICATION: For joining ferrous metals, including austenitic steels, where high joint strength up to 400 F is required, or for nonferrous metals except those having base of aluminum or magnesium.
4. COMPOSITION:

Silver	49.0	- 51.0
Cadmium	17.0	- 19.0
Zinc	14.5	- 18.5
Copper	14.5	- 16.5
Total Other Elements	0.15	max
5. CONDITION: Unless otherwise specified, material shall be furnished in the following condition:
 - 5.1 Wire: Cold drawn, annealed and pickled bright.
 - 5.2 Strip: Cold rolled hard.
 - 5.3 Pig and Granular: As fabricated.
6. TECHNICAL REQUIREMENTS:
 - 6.1 Solidus: Shall be approximately 1160 F.
 - 6.2 Liquidus: Shall be approximately 1175 F.
 - 6.3 Color: Shall be yellow-white.
7. QUALITY: Material shall be uniform in color, quality and condition, and free from foreign materials and from defects detrimental to its working qualities. Wire and strip shall be clean, sound, smooth and bright, and free from slivers, splitting, ragged edges, damaged ends and other injurious defects.
8. SIZES AND TOLERANCES: Unless otherwise specified, round wire shall be supplied in commercially standard sizes of 1/32-in., 1/16-in., 3/32-in., and 1/8-in. diameter, as ordered. Diameter may vary plus and minus 5% from that ordered.
9. REPORTS:
 - 9.1 Unless otherwise specified, the vendor of the product shall furnish with each shipment three copies of a report stating that the product conforms to the requirements specified. This report shall include the purchase order number, material specification number, form and size, and quantity.

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