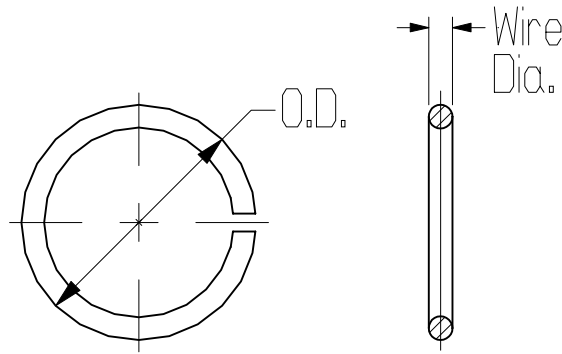


ORFS Braze Rings



Inch Tube O.D.	Air-Way Part #	Ring O.D. (in)	Wire Dia. (in)
1/4	FF9000-4	.250	.046
5/16	FF9000-5	.312	.046
3/8	FF9000-6	.375	.046
1/2	FF9000-8	.500	.046
5/8	FF9000-10	.625	.060
3/4	FF9000-12	.750	.060
7/8	FF9000-14	.875	.060
1	FF9000-16	1.000	.060
1 1/4	FF9000-20	1.250	.060
1 1/2	FF9000-24	1.500	.060
2	FF9000-32	2.000	.060

Metric Tube O.D.	Air-Way Part #	Ring O.D. (mm)	Wire Dia. (mm)
6mm	MFF9000-6	6mm	1.168
8mm	MFF9000-8	8mm	1.168
10mm	MFF9000-10	10mm	1.168
12mm	MFF9000-12	12mm	1.168
16mm	MFF9000-16	16mm	1.168
20mm	MFF9000-20	20mm	1.524
22mm	MFF9000-22	22mm	1.524
25mm	MFF9000-25	25mm	1.524
30mm	MFF9000-30	30mm	1.524
38mm	MFF9000-38	38mm	1.524
50mm	MFF9000-50	50mm	1.524

Braze Alloy Specification	Silvaloy A 50N (BAg-24)
Industry Specifications Reference	AWS A5.8-BAg-24, ASME-BAg24, AMS-4788
Properties of Brazed Joints	Generally, the joint strength using Silvaloy A-50N will surpass the strengths of the base metals. Strength is a function of the base metals being joined, type of joint, design of joint, joint clearances and brazing procedures. The recommended maximum operating temperature for Silvaloy A-50N brazed assemblies is up to 700°F (370°C).
Usage	Silver brazing alloy for brazing carbon steels or 300 series stainless steels. This alloy contains no cadmium. The addition of nickel to the silver-copper zinc alloy imparts corrosion properties, which retards joint or interface corrosion of the brazed assembly.
Nominal Composition:	
Silver	50.0 +/- 1.0%
Copper	20.0 +/- 1.0%
Zinc	28.0 +/- 2.0%
Nickel	2.0 +/- 0.5%
Total Other Elements	0.15% Max.
Physical Constants:	
Solidus	1220°F (660°C)
Liquidus	1305°F (705°C)
Brazing Range	1310-1550°F (710-843°C)
Specific Gravity	8.98
Density (T.oz./cu.in.)	4.73
Electrical Conductivity (% IACS)	15.0
Electrical Resistivity (Microohm-cm)	11.75
Color	Light Yellow
Safety Information	It is essential that adequate ventilation be provided so that personnel will not inhale gasses and fumes while 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 A-50N.

