

AERONAUTICAL MATERIAL SPECIFICATIONS

AMS 4184B

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc. 485 Lexington Ave., New York 17, N.Y.

Issued 5-1-48
Revised 1-15-59

BRAZING ALLOY, ALUMINUM 10Si - 4Cu (4145)

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
- Ø 2. FORM: Wire, sheet, pig, granular, shot, chips, or as ordered.
3. APPLICATION: Primarily for joining of aluminum by brazing.
4. COMPOSITION:

Silicon	9.3 - 10.7
Copper	3.3 - 4.7
Iron	0.8 max
Zinc	0.20 max
Chromium	0.15 max
Manganese	0.15 max
Magnesium	0.15 max
Other Impurities, each	0.05 max
Other Impurities, total	0.15 max
Aluminum	remainder
5. CONDITION: Unless otherwise specified, material shall be furnished in the following condition:
 - Ø 5.1 Round, and Flattened and Slit Wire: Annealed.
 - Ø 5.2 Sheet: Annealed.
 - Ø 5.3 Pig, Granular, Shot, and Chips: As fabricated.
6. TECHNICAL REQUIREMENTS:
 - 6.1 Solidus: When determined, shall be 970 - 1085 F.
 - 6.2 Liquidus: When determined, shall be not higher than 1095 F.
7. QUALITY: Material shall be uniform in quality and condition, clean, sound, and free from foreign materials and from internal and external imperfections detrimental to use for brazing purposes.
8. STANDARD SIZES:
 - Ø 8.1 Round Wire: 1/32, 1/16, 3/32, 1/8, 3/16, and 1/4 in. diameters.
 - 8.2 Flattened and Slit Wire: 0.020 x 2 in. cross-section.

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