

AERONAUTICAL MATERIAL SPECIFICATIONS

AMS 4769

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

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Revised

BRAZING ALLOY, SILVER 45Ag - 24Cd - 16Zn - 15Cu

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

Silver	44.0 - 46.0
Cadmium	23.0 - 25.0
Zinc	14.0 - 18.0
Copper	14.0 - 16.0
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 descaled.
 - 5.2 Strip: Cold rolled hard.
 - 5.3 Rod: As cast, with fins and projections removed.
 - 5.4 Pig, Granular, Shot, and Chips: As fabricated.
6. TECHNICAL REQUIREMENTS:
 - 6.1 Solidus: Shall be approximately 1125 F.
 - 6.2 Liquidus: Shall be approximately 1145 F.
 - 6.3 Color: Shall be yellow-white.
 - 6.4 Bending: Wire and strip 0.25 in. and under in diameter or thickness, after being heated at approximately 1000 F in air for 20 min. and air cooled, shall withstand, without cracking, bending at room temperature through an angle of 180 deg around a diameter equal to 4 times the diameter or thickness of specimen in plane of bend.