

AEROSPACE

MATERIAL SPECIFICATIONS

AMS 4767

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Revised

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

BRAZING ALLOY, SILVER
92.5Ag - 7.2Cu - 0.2Li

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.
2. FORM: Strip, wire, or as ordered.
3. APPLICATION: Primarily for brazing corrosion resistant honeycomb structures where service temperature will not exceed 900 F (480 C). Oxidation of the brazed alloy may occur during long time service at such temperatures.

4. COMPOSITION:

Silver	92.0 - 93.0
Copper	6.6 - 7.8
Lithium	0.15 - 0.30
Total Other Elements	0.15 max

Note. For the above composition, the following approximate values are listed for reference:

Solidus	1435 F (780 C)
Liquidus	1635 F (890 C)

5. CONDITION:

5.1 Strip: Cold rolled hard.

5.2 Wire: Cold drawn hard.

6. TECHNICAL REQUIREMENTS:

6.1 Color: Shall be a silvery metallic luster.

6.2 Flatness: When unrolled, strip shall lie flat with no undue tendency to recoil.

7. QUALITY: Material shall be uniform in color, quality, and condition, and free from foreign materials and from imperfections 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 imperfections.

8. SIZES AND TOLERANCES:

8.1 Strip: Unless otherwise specified, thicknesses less than 0.002 in. shall have a tolerance of ± 0.0002 ; thicknesses 0.002 in. and over shall have tolerances conforming to the latest issue of AMS 2222, Table II. Width of individual rolls of strip shall not vary more than ± 0.010 in. from nominal. The length of strip in a roll shall be as determined by the manufacturer, except that any one roll shall weigh no more than 75 pounds.