

AERONAUTICAL MATERIAL SPECIFICATIONS

AMS 4771

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

Issued 8-15-58
Revised

BRAZING ALLOY, SILVER
50Ag - 16Cd - 15.5Zn - 15.5Cu - 3Ni

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: 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	49.0	-	51.0
Cadmium	15.0	-	17.0
Zinc	13.5	-	17.5
Copper	14.5	-	16.5
Nickel	2.5	-	3.5
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 Rod: As cast, with fins and projections removed.
 - 5.4 Pig, Granular, Shot, and Chips: As fabricated.
6. TECHNICAL REQUIREMENTS:
 - 6.1 Solidus: When determined, shall be approximately 1170 F.
 - 6.2 Liquidus: When determined, shall be approximately 1270 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 imperfections detrimental to its working qualities. Wire and strip shall be smooth, clean, sound, and bright, and free from slivers, splitting, ragged edges, damaged ends, and other injurious imperfections.
8. SIZES AND TOLERANCES: Unless otherwise specified, round wire shall be supplied in commercially standard sizes of 1/32, 1/16, 3/32, and 1/8 in. diameter, as ordered. Unless otherwise specified, tolerances on diameters shall conform to the latest issue of AMS 2224, Table II, Refractory.

Section 7C of the SAE Technical Board rules provides that: "All technical reports including standards approved and practices recommended, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no requirement to conform to or be guided by any technical report. In formulating and approving technical reports, the Board and its Committees will not investigate or consider patents which may apply to the subject matter. Prospective users of the report are responsible for protecting themselves against liability for infringement of patents."