

AERONAUTICAL MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
29 West 39th Street
New York City

AMS4766

Issued 11-1-54

Revised

BRAZING ALLOY, SILVER 85Ag - 15Mn

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.
2. FORM: Wire, strip, pig, granular, or as ordered.
3. APPLICATION: For joining ferrous metals, particularly austenitic steels and alloys, where high strength up to approximately 800 F is required, or for non-ferrous metals except those having base of aluminum or magnesium.
4. COMPOSITION:

Silver	84.0 - 86.0
Manganese	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, and bright annealed, or annealed and pickled bright.
 - 5.2 Strip: Cold rolled hard.
 - 5.3 Pig and Granular: As fabricated.
6. TECHNICAL REQUIREMENTS:
 - 6.1 Solidus: Shall be approximately 1745 F.
 - 6.2 Liquidus: Shall be approximately 1760 F.
 - 6.3 Color: Shall be white.
7. QUALITY: Material shall be uniform in color, quality, and condition, and free from foreign materials and from defects 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 defects.
8. SIZES AND TOLERANCES: Unless otherwise specified, round wire shall be supplied in commercially standard sizes of 1/32 in., 1/16 in., 3/32 in., and 1/8 in. diameter, as ordered. Diameter may vary plus and minus 5% from that ordered.

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 agreement to adhere to any SAE standard or recommended practice, and no commitment 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."