

AERONAUTICAL MATERIAL SPECIFICATION

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

AMS 4770 A

Issued 3-13-40

Revised 5-1-45

B R A Z I N G A L L O Y Silver

1. ACKNOWLEDGMENT: Vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. USE: For joining non-ferrous and ferrous materials, including austenitic steels.
3. FORM: Wire, strip, pig, granular, or as ordered.
4. COMPOSITION:

Silver	49.0 - 51.0
Copper	14.5 - 16.5
Zinc	14.5 - 18.5
Cadmium	17.0 - 19.0
Total Impurities	0.15 max
5. PHYSICAL PROPERTIES: Melting point shall not exceed 1160°F; flow point shall not exceed 1175°F. Color should be yellow-white.
6. CONDITION: Unless otherwise specified, wire shall be supplied cold drawn, annealed and pickled bright; strip shall be cold rolled and hard.
7. QUALITY: Material shall be uniform in color, quality, temper, and size; clean, bright, sound, smooth; and free from ragged edges, damaged ends, or other injurious defects.
8. SIZE AND TOLERANCE: Round wire shall be supplied in the commercially standard sizes of 1/32 inch, 1/16 inch and 3/32 inch diameter, unless otherwise specified. The size may vary plus or minus 5% from that ordered.
9. REPORTS: (a) The brazing alloy vendor shall furnish three copies of a notarized report stating that the chemical composition and physical properties of the brazing alloy conform to the requirements specified. This report shall include the purchase order number, material specification number, form and size, and quantity.

(b) When parts made of this brazing alloy or assemblies requiring the use of this brazing alloy are supplied, the parts manufacturer shall inspect each lot of brazing alloy to determine conformance with this specification and shall furnish with each shipment of parts three copies of a notarized report certifying that the brazing alloy conforms to the specification. This report shall include the purchase order number, material specification number, part number, and quantity.
10. PACKAGING: The material shall be supplied in coils unless otherwise ordered.