

AERONAUTICAL MATERIAL SPECIFICATIONS

AMS 4774

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

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Revised

BRAZING ALLOY, SILVER 63Ag - 28.5Cu - 6Sn - 2.5Ni

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.
2. FORM: Wire, strip, powder, or as ordered.
3. APPLICATION: Primarily for joining ferrous alloys, including austenitic stainless steels, where moderate joint strength up to 800 F is required, or for nonferrous alloys except those having base of aluminum, magnesium, or titanium.
4. COMPOSITION:

Silver	62.0 - 64.0
Copper	27.5 - 29.5
Tin	5.0 - 7.0
Nickel	2.0 - 3.0
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 pickled bright.
 - 5.2 Strip: Cold rolled.
 - 5.3 Powder: Fine grain, particle size through 250 on 325 mesh.
 - 5.3.1 When specifically ordered, powder shall be pre-mixed with AMS 3411 flux in a ratio of one part by weight brazing alloy to one part by weight brazing flux.
6. TECHNICAL REQUIREMENTS:
 - 6.1 Solidus: When determined, shall be approximately 1275 F.
 - 6.2 Liquidus: When determined, shall be approximately 1475 F.
7. QUALITY: Material shall be uniform in quality and condition, and free from foreign materials and from imperfections detrimental to its working qualities. Wire and strip shall be clean, sound, smooth, bright, and free from slivers, splitting, ragged edges, damaged ends, and other injurious imperfections.
8. TOLERANCES: Unless otherwise specified, tolerances shall conform to the following:
 - 8.1 Diameter:
 - 8.1.1 Drawn Wire or Rod: The latest issue of AMS 2224, Table II, column headed "Refractory".