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Technical Data Sheet — ABP 20

ABP 20 · EN ISO 17672 Ag 220 · Cadmium-free silver brazing alloy

Field	Value
Product	ABP 20
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Language	English
Family	Cadmium-free silver brazing alloy

1. Product Identification

Field	Value
EN ISO 17672	Ag 220
ISO 3677	B-Ag20CuZnSi-690/810
EN 1044	AG 206
DIN 8513	L-Ag20

EN 1044 is withdrawn and superseded by EN ISO 17672; designations shown for cross-reference.

2. Chemical Composition (wt %)

Element	Min.	Max.	Nominal
Silver (Ag)	19.0	21.0	20
Copper (Cu)	43.0	45.0	44
Zinc (Zn)	34.0	38.0	36
Silicon (Si)	0.05	0.25	0.2

3. Impurity Limits (max. wt %)

Field	Value
Aluminium (Al)	≤ 0.001
Bi	≤ 0.030
Cadmium (Cd)	≤ 0.010
Phosphorus (P)	≤ 0.008
Lead (Pb)	≤ 0.025
Total other	≤ 0.15

4. Physical Properties

Field	Value
Melting range	690–810 °C
Working temperature	800 °C
Density	8.7 g/cm³
Tensile strength	330 N/mm²

Composition ranges per the referenced standard; physical data as published by Advanced Brazing Products.

5. Safety

Refer to the Safety Data Sheet (SDS) for handling, personal protective equipment, ventilation and first-aid measures.

6. Sources

EN ISO 17672 / ISO 3677 designations and composition ranges. Advanced Brazing Products published product data (www.advanced-brazing.com). Approved ABP TDS v1.0 data.

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