

Technical Data Sheet — ABP 45Sn

ABP 45Sn · EN ISO 17672 Ag 145 · Cadmium-free silver brazing alloy

Field	Value
Product	ABP 45Sn
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Language	English
Family	Cadmium-free silver brazing alloy

1. Product Identification

Field	Value
EN ISO 17672	Ag 145
ISO 3677	B-Ag45CuZnSn-640/680
EN 1044	AG 104
DIN 8513	L-Ag45Sn
AWS A5.8	BAg-36

EN 1044 is withdrawn and superseded by EN ISO 17672; designations shown for cross-reference.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)	44.0	46.0	45
Copper (Cu)	26.0	28.0	27
Zinc (Zn)	23.5	27.5	25
Tin (Sn)	2.0	3.0	3

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
Silicon (Si)	≤ 0.05
Total other	≤ 0.15

4. Physical Properties

Field	Value
Melting range	640–680 °C
Working temperature	670 °C
Density	9.2 g/cm ³
Tensile strength	350 N/mm ²

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

5. Available Forms

Foil

6. Safety

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

7. 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.

Disclaimer

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