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Current: 11.04.14
Page: 1/2

Sterling+

1. Composition

Ag	97.20 %
Cu	00.00 %

2. Physical Properties

Melting range	890 – 940°C
Density	10.40 g/cm ³
Colour	white

3. Mechanical Properties

Young's modulus	80 GPa	
Condition	cold worked	soft
Parameters	75.00 % kv	400°C/60'/H20
Hardness HV5	135	60
Tensile strength (Rm)	490 MPa	218 MPa
0.2% Proof stress (Rp 0.2%)	415 MPa	94 MPa
Elongation	8.20 %	53.00 %

4. Handling

Brazing	With a torch or in a furnace. Recommended brazing filler metal: Sterling+ 29M (art. no. 5.3041 / 733 – 793C°) and Sterling+ 28H (art. no. 5.3042 / 785 – 845C°).
Laser	Excellent results are obtained with laser.
Pickling	With diluted hot sulphuric acid (H ₂ SO ₄ , 10 %). Discoloration due to pickling can be removed by polishing.

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Page: 2/2

Remarks

Annealing (for single parts):
60 minutes at 400°C followed by quenching in water. To prevent Oxidation annealing should be done in a reducing atmosphere.

Hardening:
The alloy cannot be thermally hardened.

Straightening and thumbling:
These operations may induce a slight hardening.

Very well suited for all cold work processes (rolling, drawing, stamping, punching, bending, chasing).

Machining such as turning, milling, drilling etc. is preferably done on cold worked material.

For precision casting (lost wax process) melting and casting in vacuum or under protective atmosphere is recommended.

5. Certification

Manufacture and delivery are constantly monitored according to the quality management system standard according to ISO 9001.

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Page: 3/2

6. Graphs

