FD BRAZING DIVISION

Our product range is constantly growing. For an updated list of all our products, CLICK HERE





JFD Group Spa is an Italian company that operates in several industrial sectors since 1991, specifically in the diamond tools industry. Thanks to this long and successful experience, JFD Group founded its Brazing Division, with the aim of developing new alloys and processes.

JFD Group - Brazing Division manufactures silver brazing alloys available in a wide range of forms and dimensions. We cooperate with leading companies in several industries: diamond tools, heat exchangers, automotive, lighting, heating elements, eyewear, jewelry, etc.

Our headquarters in Cavazzale (Vicenza), with its 2.200 m² premises, qualified staff and modern production and quality control equipment, guarantee high quality standards and a fast and effective service to our customers.







All our brazing alloys comply with Regulation (CE) n. 1907/2006 (REACH) and conform to the most relevant European and International Standards.

JFD Group SpA is an ISO 9001 certified company



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ECOLOGICAL SILVER BRAZING ALLOYS FOR GENERAL PURPOSES Silver brazing alloys for general purposes are used to braze various materials such as steel, copper, nickel and their alloys. These filler metals can be employed at service temperatures between

-200°C/+200°C without compromising the mechanical properties of the joint. Our brazing alloys are available in a wide range of forms and dimensions (bare and coated rods, wire, foils, strips, rings and preforms).

N.B. All mentioned fields of

							application are for illus	trative purposes only.	
Allow	Composition (wt %)			Melting range	Density	100 17670	A)A/C		
Alloy	Ag	Cu	Zn	Other	°C	g/cm3	130 17072	AVV5	
J74100	74	18	8	-	740-780	9.8	-	-	
J65100	65	20	15	-	670-720		Ag 265	BAg-9	
J6010S	60	30		10 Sn	600-730	9.8	Ag 160	BAg-18	
J60100	60	26	14	-	695-730	9.5	-	-	
J5610S	56	22	17	5 Sn	618-652	9.5	Ag 156	BAg-7	
J5510S	55	21	22	2 Sn	630-660	9.4	Ag 155	-	
J4510S	45	27	25.5	2.5 Sn	640-680	9.1	Ag 145	Bag-36	
J45100	45	30	25	-	665-745	9.2	Ag 245	BAg-5	
J44100	44	30	26	-	675-735	9.1	Ag 244	-	
J4010S	40	30	28	2 Sn	650-710	9	Ag 140	BAg-28	
J3810S	38	32	28	2 Sn	660-720	9.1	Ag 138	BAg-34	
J3410S	34	36	27.5	2.5 Sn	630-730	9	Ag 134	-	
J33100	33	33.5	33.5	-	680-750	9	-	-	
J3010S	30	36	32	2 Sn	665-755	8.8	Ag 130	-	
J30100	30	38	32	-	680-765	8.9	Ag 230	-	
J2510S	25	40	33	2 Sn	680-760	8.8	Ag 125	BAg-37	
J25100	25	40	35	-	700-790	8.8	Ag 225	-	
J20100	20	44	35.85	-	690-810	8.7	-	-	
J16100	16	50	34	-	790-830	8.6	-	-	
J12100	12	48	40	0.15 Si	800-830	8.3	Ag 212	-	
J05100	5	55	40	0.15 Si	820-870	8.4	Ag 205	-	







Silver brazing alloys suitable for special applications, specifically for brazing tools and materials with low wettability. Technical and mechanical properties of the joint depend on the characteristics of the materials to be joined, the assembly shape and conditions, the temperature reached by the components, the heating method and the application of a proper flux. SILVER BRAZING ALLOYS FOR SPECIAL APPLICATIONS



N.B. All mentioned fields of application are for illustrative purposes only.

Alloy		Co	mposition (wt	%)	Melting range	Density	ISO 17672	AWS	
	Ag	Cu	Zn	Mn	Ni	°C	g/cm3		
J72100	72	28	-	-	-	780	10	Ag 272	BAg-8
J72200	72	-	28	-	-	710-730	8.4	-	-
J5010N	50	20	28	-	2	660-715	9.4	Ag 450	BAg-24
J492MN	49	16	23	7.5	4.5	680-705	8.9	Ag 449	BAg-22
J491MN	49	27.5	20.5	2.5	0.5	670-690	8.9	-	-
J44100	44	30	26	-		675-735	9.1	Ag 244	
J4010N	40	30	28	-	2	660-780	9	Ag 440	BAg-4
J391MN	39	31	25	3	2	670-720	8.9	-	-
J25TMN SANDWICH	49	27	21	2.5	0.5	670-690	9.0	-	-



Product	Standard dimensions					
Wire	Ø From 0.4 to 3 mm					
Strip	Thickness from 0.20 to 2 mm; Width from 3 to 20 mm					
Rods	Ø 1, 1.5, 2, 3 mm					
Flux coated rods	Ø 1.5, 2 mm					
Rings / Others	Available upon request					





PHOSPHORUS-CONTAINING ALLOYS FOR BRAZING COPPER AND COPPER ALLOYS These alloys do not require the use of fluxes when employed to braze copperto-copper; however, a flux is required when joining copper to copper alloys (e.g. brass).

Phosphorus-containing alloys are not suitable to join ferrous or nickelcontaining metals.

In order to avoid corrosion, the exposure of the joint to sulphur-containing atmospheres is not recommended.

N.B. All mentioned fields of

						i	application are for illus	trative purposes only.
Allov		Composit	ion (wt %)		Melting range	Density	150 17672	AWS
Alluy	Ag	Cu	Р	Other	°C	g/cm 3	130 17072	
J1510P	15	80	5	-	645-800	8.4	CuP 284	BCuP-5
J0510P	5	89	6	-	645-815	8.2	CuP 281	BCuP-3
J0210P	2	91.7	6.3	-	645-825	8.1	CuP 279	-
J0060P	-	93.8	6.2	-	710-890	8.1	CuP 179	-
J0070P	-	93	7	-	710-820	8.05	CuP 180	BCuP-2
J0080P	-	92	8	-	710-770	8	CuP 182	-
J002PS	-	86	7	7 Sn	650-700	8	CuP 386	-



In metal joining, choosing the right flux is as important as selecting the appropriate filler metal. The properties of the metal components to be joined, the temperature and the processing time, as well as the flux shelf life, are essential parameters, useful to identify the most suitable product.

Below you will find a list of our standard fluxes, available in 1, 10 and 25 kg packages.

BRAZING FLUXES



N.B. Any product, dimension or form not listed in this catalogue are subject to a specific request.									
Flux	Form	Working temperature	DIN EN 1045	Description					
General	Powder Paste	550-850 ° C	FH 10	Multi-purpose smooth flux suitable for most brazing alloys. It shows good resistance to flame heating.					
Universal	Powder Paste	600-870 ° C	FH 10	Multi-purpose smooth flux for medium- high temperatures, suitable for most silver-based brazing alloys. It shows very good heat resistance.					
Tek Flux	Paste	550-850° C	FH 12	Special low-hazard flux in paste form, recommended for brazing silver-based alloys; it is commonly employed to join hard metal tools.					
Special	Paste	560-980 °C	FH 12	Special flux in paste form, generally used to braze tools and when brazing operations entail long processing time.					

RESEARCH AND DEVELOPMENT -COMPOSITIONS UPON REQUEST

Our goal is to meet the requirements of all our customers.

That is why our team of R&D engineers is constantly working on new, concrete and cutting edge solutions, developing tailor-made and high-quality alloys, to meet the actual needs of each customer.





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