

**AWS Braze Alloys**

| AWS class | Solidus |      | Liquids |      | Recommended Brazing Range |           |
|-----------|---------|------|---------|------|---------------------------|-----------|
|           | °F      | °C   | °F      | °C   | °F                        | °C        |
| BAG-1     | 1125    | 607  | 1145    | 618  | 1145-1400                 | 618-760   |
| BAG-1a    | 1160    | 627  | 1175    | 635  | 1175-1400                 | 635-760   |
| BAG-2     | 1125    | 607  | 1295    | 702  | 1295-1550                 | 702-843   |
| BAG-2a    | 1125    | 607  | 1310    | 710  | 1310-1550                 | 710-843   |
| Bag-3     | 1170    | 632  | 1270    | 688  | 1270-1500                 | 688-816   |
| Bag-4     | 1240    | 671  | 1435    | 779  | 1435-1650                 | 779-899   |
| Bag-5     | 1225    | 663  | 1370    | 743  | 1370-1550                 | 743-843   |
| Bag-6     | 1270    | 688  | 1425    | 774  | 1425-1600                 | 774-871   |
| Bag-7     | 1145    | 618  | 1205    | 652  | 1205-1400                 | 652-760   |
| BAG-8     | 1435    | 779  | 1435    | 779  | 1435-1650                 | 779-899   |
| Bag-8a    | 1410    | 766  | 1410    | 766  | 1410-1600                 | 766-871   |
| Bag-9     | 1240    | 671  | 1325    | 718  | 1325-1550                 | 718-843   |
| Bag-10    | 1275    | 691  | 1360    | 738  | 1360-1550                 | 738-843   |
| Bag-13    | 1325    | 718  | 1575    | 857  | 1575-1775                 | 857-968   |
| Bag-13a   | 1420    | 771  | 1640    | 893  | 1600-1800                 | 871-982   |
| Bag-18    | 1115    | 602  | 1325    | 718  | 1325-1550                 | 718-843   |
| Bag-19    | 1400    | 760  | 1635    | 891  | 1610-1800                 | 877-982   |
| Bag-20    | 1250    | 677  | 1410    | 766  | 1410-1600                 | 799-871   |
| Bag-21    | 1275    | 691  | 1475    | 802  | 1475-1650                 | 802-899   |
| Bag-22    | 1260    | 682  | 1290    | 699  | 1290-1525                 | 699-830   |
| Bag-23    | 1760    | 960  | 1780    | 971  | 1780-1900                 | 970-1038  |
| Bag-24    | 1220    | 660  | 1305    | 707  | 1305-1550                 | 750-843   |
| Bag-26    | 1305    | 707  | 1475    | 802  | 1475-1600                 | 800-870   |
| Bag-27    | 1125    | 607  | 1375    | 746  | 1375-1575                 | 745-860   |
| Bag-28    | 1200    | 649  | 1310    | 710  | 1310-1550                 | 710-843   |
| BAG-33    | 1125    | 607  | 1260    | 682  | 1260-1400                 | 681-760   |
| BAG-34    | 1200    | 649  | 1330    | 721  | 1330-1550                 | 721-843   |
|           |         |      |         |      |                           |           |
| BAu-1     | 1815    | 991  | 1860    | 1016 | 1860-2000                 | 1016-1093 |
| BAu-2     | 1635    | 891  | 1635    | 891  | 1635-1850                 | 891-1010  |
| BAu-3     | 1785    | 974  | 1885    | 1029 | 1885-1995                 | 1029-1091 |
| BAu-4     | 1740    | 949  | 1740    | 949  | 1740-1840                 | 949-1004  |
| BAu-5     | 2075    | 1135 | 2130    | 1166 | 2130-2250                 | 1166-1232 |
| BAu-6     | 1845    | 1007 | 1915    | 1046 | 1915-2050                 | 1046-1121 |
|           |         |      |         |      |                           |           |
| BAISi-2   | 1070    | 577  | 1142    | 617  | 1110-1150                 | 599-621   |
| BAISi-3   | 970     | 521  | 1085    | 585  | 1060-1120                 | 571-621   |
| BAISi-4   | 1070    | 577  | 1080    | 582  | 1080-1120                 | 582-604   |
| BAISi-5   | 1070    | 577  | 1110    | 599  | 1090-1120                 | 588-604   |
| BAISi-7   | 1038    | 559  | 1105    | 596  | 1090-1120                 | 588-604   |
| BAISi-9   | 1044    | 562  | 1080    | 582  | 1080-1120                 | 582-604   |
| BAISi-11  | 1038    | 559  | 1105    | 596  | 1090-1120                 | 588-604   |
|           |         |      |         |      |                           |           |
| BNI-1     | 1790    | 977  | 1900    | 1038 | 1950-2200                 | 1066-1204 |
| BNI-1a    | 1790    | 977  | 1970    | 1077 | 1970-2200                 | 1077-1204 |
| BNI-2     | 1780    | 971  | 1830    | 999  | 1850-2150                 | 1010-1177 |
| BNI-3     | 1800    | 982  | 1900    | 1038 | 1850-2150                 | 1010-1177 |
| BNI-4     | 1800    | 982  | 1950    | 1066 | 1850-2150                 | 1010-1177 |
| BNI-5     | 1975    | 1079 | 2075    | 1135 | 2100-2200                 | 1149-1204 |
| BNI-6     | 1610    | 877  | 1610    | 877  | 1700-2000                 | 927-1093  |
| BNI-7     | 1630    | 888  | 1630    | 888  | 1700-2000                 | 927-1093  |
| BNI-8     | 1800    | 982  | 1850    | 1010 | 1850-2000                 | 1010-1093 |
| BNI-9     | 1930    | 1054 | 1930    | 1054 | 1950-2200                 | 1066-1204 |
| BNI-10    | 1780    | 971  | 2020    | 1104 | 2100-2200                 | 1149-1204 |
| BNI-11    | 1780    | 971  | 2003    | 1095 | 2100-2200                 | 1149-1204 |