

Data Sheet

Incusil[®] I5 (Bag-29)

Description:

High-purity silver, copper and indium alloy for vacuum brazing.

Nominal composition by weight: **61.5% Ag, 23.5% Cu and 15% In**

Prime features:

- Lowest melting of the ductile low vapor pressure alloys
- Step braze with Cusil

Typical Applications:

- Hermetic windows and assemblies
- Heat exchanger

Suggested base materials:

- Copper, Nickel, Kovar, Metallized ceramic

Physical Properties*

Liquidus Temperature	725 °C 1335 °F
Solidus Temperature	605 °C 1120 °F
Coefficient of Thermal Expansion (CTE)	18.5 x 10 ⁻⁶ /C, for 20 – 500 °C 10.3 x 10 ⁻⁶ /°F, for 68 – 932 °F
Thermal Conductivity (Calculated)	55 W/m·K 32 BTU/ft·h· °F
Density	9.8 Mg/m ³ 0.35 lb/in ³
Yield Strength (0.2% offset)	386 MPa 56 x 10 ³ lb/in ²
Tensile Strength	448 MPa 65 x 10 ³ lb/in ²
Elongation (2in/50mm gage section)	19%
Electrical Resistivity	141 x 10 ⁻⁹ ohm·m
Electrical Conductivity	7.1 x 10 ⁶ /ohm·m
Vapor Pressure (Calculated)	2.3 x 10 ⁻⁹ mm Hg @ 500 °C, 932 °F 1.7 x 10 ⁻⁷ mm Hg @ 700 °C, 1292 °F
Recommended Brazing Temperatures	
Recommended Brazing Atmospheres	10 ⁻⁵ mm Hg, H ₂ , or inert gas

* Please note that all values quoted are based on test pieces and may vary according to component design. These values are not guaranteed in any way and should only be treated as indicative values. They should be used for guidance only and for no other purpose whatsoever.

Impurity Limits

Zn	less than 0.001%
Cd	less than 0.001%
Pb	less than 0.002%
P	less than 0.002%
C	less than 0.01%

All other metallic impurities having a vapor pressure higher than 10⁻⁷ mm Hg at 500 °C are limited to 0.002% each. Impurities having a vapor pressure lower than 10⁻⁷ mm Hg at 500 °C are limited to a total of 0.075%. (This applies to all forms except powder and extrudable paste.)

Supplied as:

- Foil
- Flexibraze
- Wire
- Powder
- Extrudable paste
- Preforms

The determination as to the adaptability of any Wesgo materials to the specific needs of the Buyer is solely the Buyer's prerogative and responsibility. All technical information, data and recommendations are based on tests and accumulated experience data, which Wesgo believed to be reliable. However, the accuracy and completeness thereof are not guaranteed.