

**AWS A5.8M/A5.8:2019**  
**An American National Standard**

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# **Specification for Filler Metals for Brazing and Braze Welding**



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**An American National Standard**

**Approved by the**  
**American National Standards Institute**  
**May 21, 2019**

# **Specification for Filler Metals for Brazing and Braze Welding**

**11th Edition**

**Supersedes AWS A5.8/A5.8M:2011-AMD 1**

Prepared by the  
American Welding Society (AWS) A5 Committee on Filler Metals and Allied Materials

Under the Direction of the  
AWS Technical Activities Committee

Approved by the  
AWS Board of Directors

## **Abstract**

This specification prescribes the requirements for the classification of brazing filler metals for brazing and braze welding. The chemical composition, physical form, and packaging of more than 120 brazing filler metals are specified. The brazing filler metal groups described include aluminum, cobalt, copper, gold, magnesium, nickel, *palladium*, silver, titanium, and brazing filler metals for vacuum service. Information is provided concerning the liquidus, the solidus, the brazing temperature range, and general areas of application recommended for each brazing filler metal. Additional requirements are included for manufacture, sizes, lengths, and packaging. A guide is appended to the specification as a source of information concerning the classification system employed and the intended use of the brazing filler metals for brazing and braze welding.

This specification makes use of both the International System of Units (SI) and U.S. Customary Units. Since these are not equivalent, each must be used independently of the other.



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This standard is subject to revision at any time by the AWS A5 Committee on Filler Metals and Allied Materials. It must be reviewed every five years, and if not revised, it must be either reaffirmed or withdrawn. Comments (recommendations, additions, or deletions) and any pertinent data that may be of use in improving this standard are requested and should be addressed to AWS Headquarters. Such comments will receive careful consideration by the AWS A5 Committee on Filler Metals and Allied Materials and the author of the comments will be informed of the Committee's response to the comments. Guests are invited to attend all meetings of the AWS A5 Committee on Filler Metals and Allied Materials to express their comments verbally. Procedures for appeal of an adverse decision concerning all such comments are provided in the Rules of Operation of the Technical Activities Committee. A copy of these Rules can be obtained from the American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

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## Foreword

This foreword is not part of this standard but is included for informational purposes only.

This document is the third of the AWS A5.8 specification revisions that makes use of both the International System of Units (SI) and U.S. Customary Units. The measurements are not exact equivalents; therefore, each system must be used independently of the other without combining values in any way. In selecting rational metric units, AWS A1.1, *Metric Practice Guide for the Welding Industry*, and International Standard ISO 544, *Welding consumables—Technical delivery conditions for filler materials and fluxes — Type of product, dimensions, tolerances and markings*, are used where suitable. Tables and figures make use of both SI Units and U.S. Customary Units, which with the application of the specified tolerances provides for interchangeability of products in both the SI Units and U.S. Customary Units.

The current document is the tenth revision of the initial joint ASTM/AWS document issued in 1952. The practice of issuing filler metal specifications as joint AWS/ASTM documents was discontinued shortly after the original version of this specification was issued. The 1969 revision and all subsequent versions, developed and published by AWS, have been certified by the American National Standards Institute (ANSI). The evolution of AWS A5.8M/A5.8, *Specification for Filler Metals for Brazing and Braze Welding*, is shown below:

ASTM B260–52T, AWS A5.8–52T *Tentative Specification for Brazing Filler Metal*;  
 ASTM B260–56T, AWS A5.8–56T *Tentative Specification for Brazing Filler Metal*;  
 AWS A5.8–62T, ASTM B260–62T *Tentative Specification for Brazing Filler Metal*;  
 AWS A5.8–69, *Specification for Brazing Filler Metal*;  
 ANSI/AWS A5.8–76, *Specification for Brazing Filler Metal*;  
 ANSI/AWS A5.8–81, *Specification for Brazing Filler Metal*;  
 ANSI/AWS A5.8–89, *Specification for Filler Metals for Brazing*;  
 ANSI/AWS A5.8–92, *Specification for Filler Metals for Brazing and Braze Welding*;  
 AWS A5.8/A5.8M:2004, *Specification for Filler Metals for Brazing and Braze Welding*;  
 AWS A5.8M/A5.8:2011, *Specification for Filler Metals for Brazing and Braze Welding*; and  
 AWS A5.8M/A5.8:2011-AMD 1, *Specification for Filler Metals for Brazing and Braze Welding*

The present edition, which supersedes AWS A5.8M/A5.8:2011-AMD1, includes the following updates:

- (1) Two new brazing filler metals are added; BNi-15 and BNi-16.
- (2) Chemical composition has been adjusted for several classifications: Zr and Hf in the BTi group; a revised Be limit for the BAISi group; a revised Cd limit for non-Cd BAg filler metals; and a Ni correction to classifications RBCuZn-A and RBCuZn-B.
- (3) ASTM B215 has been added to provide a metal powder sampling standard.
- (4) ASTM E1371–05, *Standard Test Method for Gravimetric Determination of Phosphorus in Phosphorus-Copper Alloys or Phosphorus-Copper-Silver Alloys*, is no longer listed as a reference analytical method. It is included in Annex C, however, as a suggested analysis approach for certain phosphorus ranges.

All substantive updates within this document are italicized and underlined. A vertical line in the margin indicates a revision of that item from the previous edition.

The user's attention is called to the possibility that compliance with this standard may require use of an invention covered by patent rights.

By publication of this standard, no position is taken with respect to the validity of any such claim(s) or of any patent rights in connection therewith. If a patent holder has filed a statement of willingness to grant a license under these rights on reasonable and nondiscriminatory terms and conditions to applicants desiring to obtain such a license, then details may be obtained from the standards developer.

Comments and suggestions for the improvement of this standard are welcome. They should be sent to the Secretary, AWS A5 Committee on Filler Metals and Allied Materials, American Welding Society, 8669 NW 36 St, #130, Miami, FL 33166.

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# Specification for Filler Metals for Brazing and Braze Welding

## 1. General Requirements

**1.1 Scope.** This specification prescribes requirements for the classification of filler metals for brazing and braze welding. It includes brazing filler metals for brazing with or without a flux and in all protective atmospheres for various applications, including those for vacuum service.<sup>1</sup> *In the case of composite products – flux cored wire or rods, flux-coated rods, transfer tape, or paste – this standard covers only the filler metal that forms part of such products.*

**1.2 Units of Measurement.** This specification makes use of both the International System of Units (SI) and U.S. Customary Units. The measurements are not exact equivalents; therefore, each system must be used independently of the other without combining in any way when referring to material properties. The specification with the designation A5.8M uses the International System of Units. The specification A5.8 uses U.S. Customary Units. The latter are shown within brackets ([ ]) or in appropriate columns in tables and figures. Standard dimensions based on either system may be used for the sizing or packaging of brazing filler metal, or both, under A5.8M or A5.8 specifications.

**1.3 Safety.** Safety issues and concerns are addressed in this standard, although health issues and concerns are beyond the scope of this standard. Some safety and health information can be found in non-mandatory Annex B, clauses B5 and B10.

Safety and Health information is available from the following sources:

American Welding Society:

- (1) ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*
- (2) AWS Safety and Health Fact Sheets (see Annex B, clause B10)
- (3) Other safety and health information on the AWS website

Material or Equipment Manufacturers:

- (1) Safety Data Sheets supplied by the materials manufacturers
- (2) Operating Manuals supplied by equipment manufacturers

Applicable Regulatory Agencies

Work performed in accordance with this standard may involve the use of materials that have been deemed hazardous, and may involve operations or equipment that may cause injury or death. This standard does not purport to address all safety and health risks that may be encountered. The user of this standard should establish an appropriate safety program to address such risks as well as to meet applicable regulatory requirements. ANSI Z49.1 should be considered when developing the safety program.

## 2. Normative References

The standards listed below contain provisions that, through reference in this text, constitute mandatory provisions of this AWS standard. For undated references, the latest edition of the referenced standard shall apply. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply.

<sup>1</sup> Filler metals for vacuum service are for devices operating in vacuum service, regardless of the atmosphere used in making the joint.