

FEDERAL SPECIFICATION

BRAZING ALLOYS, SILVER

This amendment, which forms a part of QQ-B-654A, dated 5 September 1980, is approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal Agencies.

PAGE 2

2.1, under "Military Standard" Add:

"MIL-STD-105 - Sampling Procedures and Tables for Inspection By Attributes."

PAGE 5

3.3, title: Delete and substitute: "Form, size and tolerances".

3.3.1, line 2: Delete "forms and sizes" and substitute "forms, sizes and tolerances".

3.3.2, line 2: Delete "forms and sizes" and substitute "forms, sizes and tolerances".

Table II: Delete and substitute:

TABLE II. Forms, sizes, and tolerances for BAg-XX.

Form	Nominal diameter (inches)	Permissible variation in diameter, plus or minus		
		Drawn wire (inches)	Drawn rod (inches)	Rolled or extruded wire and rod (inches)
Wire in coils, spools and rods	1/32 (0.031)	0.0007	0.003	-----
	3/64 (.047)	.0008	.003	0.005
	1/16 (.063)	.0015	.003	.005
	3/32 (.094)	.0020	.003	.006
	1/8 (.125)	.0020	.003	.006
Form	Nominal ^{1/} width (inches)	Permissible variation in width plus or minus (inches)	Nominal thickness (inches)	Permissible variation in thickness plus or minus (inches)
Strip in coils and spools	0.250 to 1.000	+ 0.003	0.002	+ 0.0003
	1.001 to 4.000	+ .005	.003	+ .0003
	4.001 to 6.000	+ .008	.005	+ .0004
			.010	+ .0008
		.020	+ .0012	

^{1/} Strip widths 0.25 to 6 inches by multiples of 0.25 inches.

PAGE 6

3.3.3: Delete and substitute:

"3.3.3 Mixed lengths. Where brazing alloy is furnished specifying 18-inch or 36-inch lengths, any single package may contain pieces shorter than specified, but the number of short pieces shall not exceed 10 percent of the total number in the package, and no short piece shall be less than 60 percent of the nominal length specified."

3.4.1: Delete and substitute:

"3.4.1 Strips or wire in coils and rods. Strip or wire in coils or rods shall be identified by positive and legible methods such as imprinting or indenting the applicable classification designation on the surface of the brazing alloy or shall be identified by pressure-sensitive plastic coated tape imprinted with the applicable classification designation and attached to the brazing alloy. The identification shall be placed 1-inch from the end of each strip and rod, and 1-inch from the inner end of wire in each coil. Imprinting on the surface of the brazing alloy or on tapes shall be with fade-proof ink and shall be resistant to oils, solvents, and all atmospheric conditions, and to normal wear and tear encountered in shipping and handling."

Add as new paragraph 3.4.1.1:

"3.4.1.1 Wire on spools. Wire on spools too small to be marked by the method of 3.4.1 shall be identified by marking with fade-proof ink on the flange along with other marking required by 5.3."

Add as new paragraph 3.4.1.2:

"3.4.1.2 Preformed rings. Preformed rings shall be identified by the method of 3.4.1 or when furnished in individual envelopes preformed rings shall be identified by marking with fade-proof ink on the envelopes along with other marking required by 5.3."

PAGE 7

4.4.1: Add: "Chemical analysis shall be in accordance with method 111.2 or method 112.2 of FED-STD-151."

PAGE 8

4.4.2: Add: "In case of dispute, chemical analysis shall be in accordance with method 111.2 of FED-STD-151."

5.1.2: Delete and substitute:

"5.1.2 Level C. Brazing alloy in strip or wire in coils or on spools, preformed rings, rods or powder form in the quantity specified (see 6.2), shall be packaged to afford protection against deterioration, damage, or loss of contents during shipment from the supply source to the first receiving activity for immediate use. The contractor's normal retail or wholesale packaging methods may be utilized when such meets the requirements of this level."

PAGES 9 and 10

5.3.1.1: Delete and substitute:

"5.3.1.1 Interior packages. Shipment marking information for brazing alloy shall be provided on interior packages. The information shall include lot identification, classification, length, size when applicable, specification number, manufacturer's or distributor's name, manufacturer's or distributor's brand or type designation. In addition, all packages or the smallest intergral unit within a shipping container shall carry one of the following warning labels or equivalent, prominently displayed in legible type on the package as applicable:

AMENDMENT 1

WARNING: Protect yourself and others. Read and understand this label.

FUMES AND GASES can be dangerous to your health. **HEAT RAYS (INFRARED RADIATION** from flame or hot metal) can injure eyes.

Read and understand the manufacturer's instructions and your employer's safety practices.

Keep your head out of the fumes.

Use enough ventilation, exhaust at the flame, or both, to keep fumes and gases from your breathing zone, and the general area.

Wear correct eye, ear, and body protection.

See American National Standard Z49.1 Safety in Welding and Cutting published by the American Welding Society, 550 N.W. LeJeune Rd., P.O. Box 351040 Miami, FL 33135; OSHA Safety and Health Standard, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C., 20402.

DO NOT REMOVE THIS LABEL

WARNING

CONTAINS CADMIUM

POISONOUS FUMES AND GASES MAY BE FORMED ON HEATING

Do not breath fumes and gases. Use only with adequate ventilation such as fume collectors, exhaust ventilators or air-supplied respirators.

If chest pain, cough or, fever develops after use, call physician immediately. Keep children away when using.

See American National Standard Z49.1,
SAFETY IN WELDING AND CUTTING
Published by the American Welding Society,
550 N.W. LeJeune Road, P.O. Box 351040
Miami, FL 33135."

DO NOT REMOVE THIS LABEL

LAST PAGE

DD 1426, Standardization Document Improvement Proposal: Delete address and substitute:

"COMMANDER
NAVAL SEA SYSTEMS COMMAND (SEA 5523)
DEPARTMENT OF THE NAVY
WASHINGTON, DC 20362".

MILITARY INTEREST

Custodians

Army - AR
Navy - SH

Review Activities

Army - ME, MD
Navy - YD

User Activities

Navy - MC
Air Force - 84

CIVIL AGENCY COORDINATING ACTIVITY:

GSA - FSS

Preparing Activity:

Navy - SH
(Project 3439-0450)