



# CEWELD L-Ag60Sn

|                                                   |                                                                                                                                                                                                                                                                                                          |                                |                                |                              |  |
|---------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|--------------------------------|------------------------------|--|
| TYPE                                              | High Silver containing Cadmium free brazing alloy.                                                                                                                                                                                                                                                       |                                |                                |                              |  |
| APPLICATIONS                                      | Joining: Steels, Cast iron, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals. Do not use this alloy above working temperatures of 200 °C                                                                                       |                                |                                |                              |  |
| PROPERTIES                                        | High silver containing universal silver brazing alloy without Cadmium with low operating temperature and high mechanical properties. Due to the addition of Sn. this alloy will show a bright looking joint and is more capillary then the standard silver brazing alloys. Flux/Paste: CEWELD Super-Flux |                                |                                |                              |  |
| CLASSIFICATION                                    | AWS<br>EN ISO                                                                                                                                                                                                                                                                                            | A 5.8: BAg-18<br>17672: Ag 160 |                                |                              |  |
| SUITABLE FOR                                      | Brazing: Steels, Cast iron, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.                                                                                                                                                  |                                |                                |                              |  |
| APPROVALS                                         |                                                                                                                                                                                                                                                                                                          |                                |                                |                              |  |
| WELDING POSITIONS                                 |                                                                                                                                                                                                                         |                                |                                |                              |  |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | Cu<br>30                                                                                                                                                                                                                                                                                                 | Sn<br>10                       | Ag<br>60                       |                              |  |
| MECHANICAL PROPERTIES                             | Heat Treatment<br>As Welded                                                                                                                                                                                                                                                                              | R <sub>p0,2</sub><br>(MPa)     | R <sub>m</sub><br>(MPa)<br>420 | A5<br>(%)<br>Hardness<br>HRc |  |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                             |                                |                                |                              |  |
| MELTING RANGE                                     | 600 - 730°C                                                                                                                                                                                                                                                                                              |                                |                                |                              |  |
| GAS ACC. EN ISO 14175                             |                                                                                                                                                                                                                                                                                                          |                                |                                |                              |  |