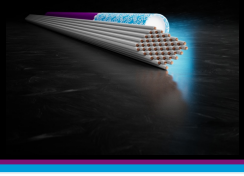

CEWELD L-Ag55Sn F

certilas® THE FILLER METAL SPECIALIST

TYPE	High Silver containing Cadmium free brazing Alloy.
TOEPASSINGEN	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
EIGENSCHAPPEN	CEWELD L-Ag55Sn F is a flux-coated brazing rod (F). It is a 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.

CLASSIFICATIE

AWS	A 5.8: BAg-7
EN ISO	17672: Ag 156

GESCHIKT VOOR

Brazing: Steels, Cast iron, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.

GOEDKEURINGEN

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Cu	Zn	Sn	Ag
22	18	5	56

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded		400		HRc

HERDROGEN	Not required
MELTING RANGE	620 - 650°C
GAS ACC. EN ISO 14175	None