



# CEWELD L-Ag20

TYPE	Silver containing cadmium free brazing alloy										
ANWENDUNGEN	Alloyed and unalloyed steel, nickel and nickel alloys, Malleable Iron, Copper and Copper alloys and hard metals. When brass is soldered, the colors are largely the same. The silicon in the solder can lower the mechanical quality values when brazing carbon steels										
EIGENSCHAFTEN	L-Ag20 is a Silver-containing, superheat-resistant silver solder alloy without Cadmium for gap and joint soldering Flux/Paste: CEWELD Super-Flux										
KLASSIFIKATION	EN ISO 17672: Ag 220										
GEEIGNET FÜR	Brazing: Steels, Copper, Copper Alloys, Stainless steel, Nickel, Nickel Alloys and Malleable Cast Iron. Also suitable for dissimilar joints between these metals. Heat resistant up to 300°C.										
ZULASSUNGEN											
SCHWEISSPOSITIONEN											
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Si</td> <td style="width: 25%;">Cu</td> <td style="width: 25%;">Zn</td> <td style="width: 25%;">Ag</td> </tr> <tr> <td>0.1</td> <td>44</td> <td>36</td> <td>20</td> </tr> </table>	Si	Cu	Zn	Ag	0.1	44	36	20		
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MECHANISCHE GÜTEWERTE	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Heat Treatment</td> <td style="width: 15%;">R<sub>P0.2</sub> (MPa)</td> <td style="width: 15%;">R<sub>m</sub> (MPa)</td> <td style="width: 10%;">A<sub>5</sub> (%)</td> <td style="width: 35%;">Hardness</td> </tr> <tr> <td>As Welded</td> <td></td> <td>430</td> <td></td> <td>HRc</td> </tr> </table>	Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness	As Welded		430		HRc
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As Welded		430		HRc							
RÜCKTROCKNUNG	Not required										
MELTING RANGE	690 - 810°C										
GAS ACC. EN ISO 14175											