



# CEWELD L-Ag49NiMn

**TYPE** Silver brazing alloy for joining steel to Tungsten and other difficult to braze composites.

**APPLICATIONS** Typical base materials: Hard metal and materials that are difficult to wet, such as Tungsten, Molybdenum, Tantalum and Chrome.

**PROPERTIES** CEWELD® L-Ag49niMn is a very good flowing, low-melting silver hard solder for operating temperatures from -200 °C to Max. 200 °C (without loss of strength) Flux/Paste: CEWELD Super-Flux

**CLASSIFICATION** AWS A 5.8: BAg-22  
EN ISO 17672: Ag 449

**SUITABLE FOR** Brazing tungsten tool tips, diamont, widia, and molybdenum alloys to steel

**APPROVALS**

**WELDING POSITIONS**



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	Mn	Ni	Cu	Zn	Ag
	7.5	4.5	16	23	49

MECHANICAL PROPERTIES	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
	As Welded		350		HRc

**REDRYING** Not required

**MELTING RANGE** 680 - 705°C

**GAS ACC. EN ISO 14175**