


CEWELD L-Ag55Sn F

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	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.										
CLASSIFICATION	AWS A 5.8: BAg-7 EN ISO 17672: Ag 156										
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 (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Cu</td> <td style="width: 25%;">Zn</td> <td style="width: 25%;">Sn</td> <td style="width: 25%;">Ag</td> </tr> <tr> <td>22</td> <td>18</td> <td>5</td> <td>56</td> </tr> </table>	Cu	Zn	Sn	Ag	22	18	5	56		
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MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Heat Treatment</td> <td style="width: 25%;">R_{P0,2} (MPa)</td> <td style="width: 15%;">R_m (MPa)</td> <td style="width: 10%;">A5 (%)</td> <td style="width: 25%;">Hardness</td> </tr> <tr> <td>As Welded</td> <td></td> <td>400</td> <td></td> <td>HRc</td> </tr> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	As Welded		400		HRc
Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness							
As Welded		400		HRc							
REDRYING	Not required										
MELTING RANGE	620 - 650°C										
GAS ACC. EN ISO 14175	None										