



CEWELD L-Ag49NiMn

TYPE High silver containing cadmium free brazing alloy

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

EIGENSCHAPPEN 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

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

GESCHIKT VOOR Brazing tungsten tool tips, diamont, widia, and molybdenium alloys to steel

GOEDKEURINGEN

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Mn	Ni	Cu	Zn	Ag
7.5	4.5	16	23	49

MECHANISCHE WAARDEN

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded		350		HRc

HERDROGEN Not required

MELTING RANGE 680 - 705°C

GAS ACC. EN ISO 14175