



CEWELD L-Ag55Sn F

TYPE	High Silver containing Cadmium free brazing Alloy.			
ANWENDUNGEN	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			
EIGENSCHAFTEN	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.			
KLASSIFIKATION	AWS EN ISO	A 5.8: BAg-7 17672: Ag 156		
GEEIGNET FÜR	Brazing: Steels, Cast iron, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.			
ZULASSUNGEN				
SCHWEISSPOSITIONEN	      			
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	Cu 22	Zn 18	Sn 5	Ag 56
MECHANISCHE GÜTEWERTE	Heat Treatment As Welded	R _{P0,2} (MPa)	R _m (MPa) 400	A5 (%) Hardness HRc
RÜCKTROCKNUNG	Not required			
MELTING RANGE	620 - 650°C			
GAS ACC. EN ISO 14175	None			