



CEWELD L-Ag27

TYPE	Silver containing cadmium free brazing alloy	
APPLICATIONS	Solder for typical base materials: hard metals and materials that are difficult to wet, such as tungsten, molybdenum, tantalum and chrome.	
PROPRIÉTÉS	L-Ag27 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	EN ISO	17672: Ag 427

CONVIENT POUR Brazing Tungsten tool tips, widia, and Molybdenum Alloys to steel

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	Mn	Ni	Cu	Zn	Ag
	9.5	5.5	38	20	27

PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
	As Welded		250		HRc

ETUVAGE Not required

MELTING RANGE 680 - 830°C

GAS ACC. EN ISO 14175