



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				
PROPRIÉTÉS	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 than the standard silver brazing alloys.				
CLASSIFICATION	AWS EN ISO	A 5.8: BAg-7 17672: Ag 156			
CONVIENT POUR	Brazing: Steels, Cast iron, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.				
AGRÉMENTS					
POSITIONS DE SOUDAGE					
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	Cu 22	Zn 18	Sn 5	Ag 56	
PROPRIÉTÉS MÉCANIQUES	Heat Treatment As Welded	$R_{P0.2}$ (MPa)	Rm (MPa) 400	A5 (%)	Hardness HRc
ETUVAGE	Not required				
MELTING RANGE	620 - 650°C				
GAS ACC. EN ISO 14175	None				