

CEWELD L-Ag49NiMn

TYPE	High silver containing cadmium free brazing alloy
ANWENDUNGEN	Typical base materials: Hard metal and materials that are difficult to wet, such as Tungsten, Molybdenum, Tantalum and Chrome.
EIGENSCHAFTEN	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
KLASSIFIKATION	AWS A 5.8: BAg-22 EN ISO 17672: Ag 449
GEEIGNET FÜR	Brazing tungsten tool tips, diamont, widia, and molybdenum alloys to steel

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Mn	Ni	Cu	Zn	Ag
7.5	4.5	16	23	49

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded		350		HRc

RÜCKTROCKNUNG Not required

MELTING RANGE 680 - 705°C

GAS ACC. EN ISO 14175