


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	A 5.8: BAg-7			
	EN ISO	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					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	Cu	Zn	Sn	Ag	
	22	18	5	56	
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
	As Welded		400		HRc
RÜCKTROCKNUNG	Not required				
MELTING RANGE	620 - 650°C				
GAS ACC. EN ISO 14175	None				