

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



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Mn	Ni	Cu	Zn	Ag
9.5	5.5	38	20	27

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded		250		HRc

ETUVAGE Not required

MELTING RANGE 680 - 830°C

GAS ACC. EN ISO 14175