



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			
PROPERTIES	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.			
CLASSIFICATION	AWS EN ISO	A 5.8: BAg-7 17672: Ag 156		
SUITABLE FOR	Brazing: Steels, Cast iron, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.			
APPROVALS				
WELDING POSITIONS				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	Cu 22	Zn 18	Sn 5	Ag 56
MECHANICAL PROPERTIES	Heat Treatment As Welded	R _{P0,2} (MPa)	R _m (MPa) 400	A5 (%) Hardness HRc
REDRYING	Not required			
MELTING RANGE	620 - 650°C			
GAS ACC. EN ISO 14175	None			