


CEWELD L-Ag49NiMn

TYPE	Silver brazing alloy for joining steel to Tungsten and other difficult to braze composites.				
APPLICATIONS	Typical base materials: Hard metal and materials that are difficult to wet, such as Tungsten, Molybdenum, Tantalum and Chrome.				
PROPERTIES	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				
CLASSIFICATION	AWS EN ISO	A 5.8: BAg-22 17672: Ag 449			
SUITABLE FOR	Brazing tungsten tool tips, diamont, widia, and molybdenium alloys to steel				
APPROVALS	No Approvals Found				
WELDING POSITIONS					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	Mn 7.5	Ni 4.5	Cu 16	Zn 23	Ag 49
ALL WELD MECHANICAL PROPERTIES	Heat Treatment As Welded /	R _{P0,2} MPa	R _m MPa 350	A5 (%)	
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175					