


CEWELD L-Ag20

TYPE	Silver containing cadmium free brazing alloy								
APPLICATIONS	Alloyed and unalloyed steel, nickel and nickel alloys, Malleable Iron, Copper and Copper alloys and hard metals. When brass is soldered, the colors are largely the same. The silicon in the solder can lower the mechanical quality values when brazing carbon steels								
PROPERTIES	L-Ag20 is a Silver-containing, superheat-resistant silver solder alloy without Cadmium for gap and joint soldering Flux/Paste: CEWELD Super-Flux								
CLASSIFICATION	EN ISO 17672: Ag 220								
SUITABLE FOR	Brazing: Steels, Copper, Copper Alloys, Stainless steel, Nickel, Nickel Alloys and Malleable Cast Iron. Also suitable for dissimilar joints between these metals. Heat resistant up to 300°C.								
APPROVALS	No Approvals Found								
WELDING POSITIONS									
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Si</td> <td style="width: 25%;">Cu</td> <td style="width: 25%;">Zn</td> <td style="width: 25%;">Ag</td> </tr> <tr> <td>0.1</td> <td>44</td> <td>36</td> <td>20</td> </tr> </table>	Si	Cu	Zn	Ag	0.1	44	36	20
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 30%;">Heat Treatment</th> <th style="width: 10%;">R_{p0,2} MPa</th> <th style="width: 10%;">R_m MPa</th> <th style="width: 10%;">A₅ (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td></td> <td>430</td> <td></td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	As Welded /		430	
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As Welded /		430							
REDRYING TEMPERATURE	Not required								
GAS ACCORDING EN 14175									