


# 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 A 5.8: BAg-7 EN ISO 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	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%;">Cu</td> <td style="width: 25%;">Zn</td> <td style="width: 25%;">Sn</td> <td style="width: 25%;">Ag</td> </tr> <tr> <td>22</td> <td>18</td> <td>5</td> <td>56</td> </tr> </table>	Cu	Zn	Sn	Ag	22	18	5	56
Cu	Zn	Sn	Ag						
22	18	5	56						
ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 33%;">Heat Treatment</td> <td style="width: 16.5%;">R<sub>p0,2</sub> MPa</td> <td style="width: 16.5%;">R<sub>m</sub> MPa</td> <td style="width: 16.5%;">A<sub>5</sub> (%)</td> </tr> <tr> <td>As Welded /</td> <td></td> <td>400</td> <td></td> </tr> </table>	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	As Welded /		400	
Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)						
As Welded /		400							
REDRYING TEMPERATURE	Not required								
GAS ACCORDING EN 14175	None								