



# CEWELD L-Ag49NiMn

|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                            |                                |           |                 |
|------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|--------------------------------|-----------|-----------------|
| TYPE                                           | High silver containing cadmium free brazing alloy                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                            |                                |           |                 |
| ANWENDUNGEN                                    | Typical base materials: Hard metal and materials that are difficult to wet, such as Tungsten, Molybdenum, Tantalum and Chrome.                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                            |                                |           |                 |
| EIGENSCHAFTEN                                  | 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)<br>Flux/Paste: CEWELD Super-Flux                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                                |           |                 |
| KLASSIFIKATION                                 | AWS<br>EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                            | A 5.8: BAg-22<br>17672: Ag 449 |           |                 |
| GEEIGNET FÜR                                   | Brazing tungsten tool tips, diamont, widia, and molybdenum alloys to steel                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                            |                                |           |                 |
| ZULASSUNGEN                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                            |                                |           |                 |
| SCHWEISSPOSITIONEN                             |        |                            |                                |           |                 |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | Mn<br>7.5                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Ni<br>4.5                  | Cu<br>16                       | Zn<br>23  | Ag<br>49        |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment<br>As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa)<br>350 | A5<br>(%) | Hardness<br>HRc |
| RÜCKTROCKNUNG                                  | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                                |           |                 |
| MELTING RANGE                                  | 680 - 705°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                            |                                |           |                 |
| GAS ACC. EN ISO 14175                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                            |                                |           |                 |