



# CEWELD L-Ag45Sn

|                |                                                                                                                                                                                                                                                                                                |
|----------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TYPE           | 45% Silver brazing alloy without Cadmium.                                                                                                                                                                                                                                                      |
| APPLICATIONS   | Brazing a weight range of different metals in maintenance and repair with excellent strength, Boiler making, Tubing, Cooling equipment etc. Do not use this alloy above working temperatures of 200 °C                                                                                         |
| PROPERTIES     | Most universal silver brazing alloy without Cadmium with extreme 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. Flux/Paste: CEWELD Super-Flux |
| CLASSIFICATION | AWS A 5.8: BAg-36<br>EN ISO 17672: Ag 145                                                                                                                                                                                                                                                      |
| SUITABLE FOR   | Steels, Copper, Copper alloys, Stainless steel, Cast Iron, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.                                                                                                                                                 |

## APPROVALS

## WELDING POSITIONS



## TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| Cu | Zn | Sn  | Ag |
|----|----|-----|----|
| 27 | 25 | 2.8 | 45 |

## MECHANICAL PROPERTIES

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded      |                         | 400                  |        | HRc      |

REDRYING Not required

MELTING RANGE 640 - 680°C

GAS ACC. EN ISO 14175