



CEWELD L-Ag45Sn

TYPE	High silver containing Cadmium free brazing alloy.													
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													
PROPRIÉTÉS	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 EN ISO	A 5.8: BAg-36 17672: Ag 145												
CONVIENT POUR	Steels, Copper, Copper alloys, Stainless steel, Cast Iron, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.													
AGRÉMENTS														
POSITIONS DE SOUDAGE														
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	<table><tr><td>Cu</td><td>Zn</td><td>Sn</td><td>Ag</td></tr><tr><td>27</td><td>25</td><td>2.8</td><td>45</td></tr></table>	Cu	Zn	Sn	Ag	27	25	2.8	45					
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PROPRIÉTÉS MÉCANIQUES	<table><tr><td>Heat Treatment</td><td>R_{P0,2} (MPa)</td><td>R_m (MPa)</td><td>A5 (%)</td><td>Hardness</td></tr><tr><td>As Welded</td><td></td><td>400</td><td></td><td>HRc</td></tr></table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	As Welded		400		HRc			
Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness										
As Welded		400		HRc										
ETUVAGE	Not required													
MELTING RANGE	640 - 680°C													
GAS ACC. EN ISO 14175														