



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			
PROPRIÉTÉS	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		
CONVIENT POUR	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.			
AGRÉMENTS				
POSITIONS DE SOUDAGE	 PA  PB  PC  PD  PE  PF  PG			
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	Si	Cu	Zn	Ag
	0.1	44	36	20
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)
	As Welded		430	
ETUVAGE	Not required			
MELTING RANGE	690 - 810°C			
GAS ACC. EN ISO 14175				