



# CEWELD L-Ag27

**TYPE** Silver containing cadmium free brazing alloy

**APPLICATIONS** Solder for typical base materials: hard metals and materials that are difficult to wet, such as tungsten, molybdenum, tantalum and chrome.

**PROPERTIES** L-Ag27 is a Very good flowing, low-melting silver hard solder for operating temperatures from -200 °C to Max. 200 °C (without loss of strength) Flux/Paste: CEWELD Super-Flux

**CLASSIFICATION** EN ISO 17672: Ag 427

**SUITABLE FOR** Brazing Tungsten tool tips, widia, and Molybdenum Alloys to steel

**APPROVALS**

**WELDING POSITIONS**



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

Mn	Ni	Cu	Zn	Ag
9.5	5.5	38	20	27

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded		250		HRc

**REDRYING** Not required

**MELTING RANGE** 680 - 830°C

**GAS ACC.** EN ISO 14175