



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 (%)	Hardness
	As Welded		430		HRc
ETUVAGE	Not required				
MELTING RANGE	690 - 810°C				
GAS ACC. EN ISO 14175					