

L-Ag30Sn

CATEGORY Brazing

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. The presence of tin improves the fluidity is useful to increase the activity of the flux. Do not use this alloy above working temperatures of 200°C .

CLASSIFICATION

AWS	A 5.8: no standard
EN ISO	1044: AG 107 17672: Ag 130
DIN	8513: L-Ag30Sn

SUITABLE FOR Brazing: Steels, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.

WELDING POSITIONS:



Ag	Cu	Zn	Sn	Others
30	36	32	2	-

MECHANICAL PROPERTIES

Heat Treatment	Rm (N/mm ²)	Weight (g/cm ³)	Operating temperature °C	Melting range °C
As brazed	460	8,9	750	680-765

WELDING PARAMETERS PACKING

Welding Parameters	Length	Flame type	Optimum brazing	Packing
D (mm)	(mm)	Adjustment	Gab (mm)	kg / tube / carton
2,0	500	Neutral	0.05-0.13	1 / 5 / 20
3,0	500	Neutral	0.05-0.13	1 / 5 / 20

REDRYING TEMPERATURE not required

OTHER DELIVERY FORMS Fluxcoated rods (F), endless wire on spools and customized brazing rings.