

L-Ag45Sn

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. Do not use this alloy above working temperatures of 200°C

PROPERTIES 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 than the standard silver brazing alloys.

CLASSIFICATION

AWS	A 5.8: BAg-36
EN ISO	1044: AG 104
	17672: Ag 145
DIN	8513: L-Ag45Sn

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

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS %

Ag	Cu	Zn	Sn
45	27	25	3

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	Weight g/cm ³	Operating temperature		Impact Energy (J) ISO-V		Melting range °C
				°C		-40°C	-60°C	
As brazed		400	9.2	670				640-680

BRAZING PARAMETERS / PACKING

Sizes		Flame type Adjustment	Optimum brazing Gab (mm)	Packing	
D (mm)	Length (mm)			kg / tube / carton	kg / spools
1.5	500	Neutral	0,01-0,25	1 / 5 / 20	1 till 10
2.0	500	Neutral	0,01-0,25	1 / 5 / 20	1 till 10
3.0	500	Neutral	0,01-0,25	1 / 5 / 20	1 till 10

REDRYING TEMPERATURE not required

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