

L-Ag55Sn

CATEGORY Brazing

TYPE High silver containing cadmium free brazing alloy.

APPLICATIONS Joining: Steels, Cast iron, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals. Do not use this alloy above working temperatures of 200°C

PROPERTIES High silver containing universal silver brazing alloy without cadmium with 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-7
EN ISO	1044: AG 102 17672: Ag 156
DIN	8513: L-Ag55Sn

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

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS %

Ag	Cu	Zn	Sn
55	22	17	5

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	9.5	650				620-650

BRAZING PARAMETERS / PACKING

Welding Parameters		Flame type	Optimum brazing	Packing	
D (mm)	Length (mm)	Adjustment	Gab (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

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