

## 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	3677: B Cu 36Zn Ag Sn 680-765
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.

Ag	Cu	Zn	Sn	Others
30	36	32	2	-

### MECHANICAL PROPERTIES

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

### WELDING PARAMETERS PACKING

Welding Parameters	Length (mm)	Flame type Adjustment	Optimum brazing Gab (mm)	Packing kg / tube / carton
D (mm)				
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.