

L-Ag40Sn

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 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-28
EN ISO	1044: AG 105
DIN	8513: L-Ag40Sn

SUITABLE FOR Brazing: Steels, 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	Ni	Mo
40	30	28	2		

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	Weight g/cm ³	Operating temperature °C	Impact Energy (J) ISO-V -40°C -60°C	Melting range °C
As brazed		400	9.1	690		650-710

BRAZING PARAMETERS / PACKING

Sizes		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

REDRYING TEMPERATURE not required

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