

## 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 | 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 <sub>p0,2</sub><br>(N/mm <sup>2</sup> ) | R <sub>m</sub><br>(N/mm <sup>2</sup> ) | Weight<br>g/cm <sup>3</sup> | Operating temperature |  | Melting range<br>°C |
|----------------|---|--|-----------------------------|-----------------------|--|---------------------|
|                |   |  |                             | °C                    | Impact Energy (J) ISO-V<br>-40°C -60°C |                     |
| As brazed      |   | 400                                    | 9.2                         | 670                   |  | 640-680             |

**BRAZING PARAMETERS / PACKING**

| Sizes  |             | Flame type<br>Adjustment | Optimum brazing<br>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.