

CATEGORY	Brazing	
TYPE	Silver containing cadmium free brazing alloy	
APPLICATIONS	Alloyed and unalloyed steel, nickel and nickel alloys, Malleable Iron, Copper and Copper alloys and hard metals. When brass is soldered, the colors are largely the same. The silicon in the solder can lower the mechanical quality values when brazing carbon steels	
PROPERTIES	L-Ag20 is a Silver-containing, superheat-resistant silver solder alloy without Cadmium for gap and joint soldering Flux/Paste: CEWELD Super-Flux	
CLASSIFICATION	EN ISO	17672: Ag 220

SUITABLE FOR Brazing: Steels, Copper, Copper Alloys, Stainless steel, Nickel, Nickel Alloys and Malleable Cast Iron. Also suitable for dissimilar joints between these metals. Heat resistant up to 300°C.

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Si	Cu	Zn	Ag
0.1	44	36	20

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A5 (%)
As Welded /		430	

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	LENGTH (MM)	CURRENT (A)	KG / CAN	KG / 6PACK	KG / 1000

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175