

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. Flux/Paste: CEWELD Super-Flux	
CLASSIFICATION	AWS EN ISO	A 5.8: BAg-18 17672: Ag 160
SUITABLE FOR	Brazing: Steels, Cast iron, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Cu	Sn	Ag
30	10	60

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)
As Welded /		420	

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	FLAME TYPE	OPTIMUM BRAZING	PACKING	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
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GAS ACCORDING EN 14175