



CEWELD L-Ag20

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				
WELDING POSITIONS				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	Si	Cu	Zn	Ag
	0.1	44	36	20
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)
	As Welded		430	
REDRYING	Not required			
MELTING RANGE	690 - 810°C			
GAS ACC. EN ISO 14175				