

# 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 <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded		430		HRc

REDRYING Not required

MELTING RANGE 690 - 810°C

GAS ACC. EN ISO 14175