



CEWELD L-Ag55Sn F

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 CEWELD L-Ag55Sn F is a flux-coated brazing rod (F). It is a 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 then the standard silver brazing alloys.

CLASSIFICATION AWS A 5.8: BAg-7
EN ISO 17672: Ag 156

SUITABLE FOR Brazing: Steels, Cast iron, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Cu	Zn	Sn	Ag
22	18	5	56

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded		400		HRc

REDRYING Not required

MELTING RANGE 620 - 650°C

GAS ACC. EN ISO 14175 None