



# 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                                                                                                                                                                                                                                                                                                                                           |                            |                         |           |          |
| PROPRIÉTÉS                                           | L-Ag20 is a Silver-containing, superheat-resistant silver solder alloy without Cadmium for gap and joint soldering<br>Flux/Paste: CEWELD Super-Flux                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                            |                         |           |          |
| CLASSIFICATION                                       | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 17672: Ag 220              |                         |           |          |
| CONVIENT POUR                                        | 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.                                                                                                                                                                                                                                                                                                                                                                                                                    |                            |                         |           |          |
| AGRÉMENTS                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                         |           |          |
| POSITIONS DE SOUDAGE                                 | <div>PAPBPCPDPEPFPG</div> |                            |                         |           |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | Si                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Cu                         | Zn                      | Ag        |          |
|                                                      | 0.1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 44                         | 36                      | 20        |          |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                            | 430                     |           | HRc      |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                            |                         |           |          |
| MELTING RANGE                                        | 690 - 810°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                            |                         |           |          |
| GAS ACC. EN ISO 14175                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                         |           |          |