



CEWELD L-Ag49NiMn

TYPE	High silver containing cadmium free brazing alloy	
TOEPASSINGEN	Typical base materials: Hard metal and materials that are difficult to wet, such as Tungsten, Molybdenum, Tantalum and Chrome.	
EIGENSCHAPPEN	CEWELD [®] L-Ag49niMn is a very good flowing, low-melting silver hard solder for operating temperatures from -200 °C to Max. 200 °C (without loss of strength) Flux/Paste: CEWELD Super-Flux	
CLASSIFICATIE	AWS EN ISO	A 5.8: BAg-22 17672: Ag 449

GESCHIKT VOOR Brazing tungsten tool tips, diamont, widia, and molybdenum alloys to steel

GOEDKEURINGEN

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	Mn	Ni	Cu	Zn	Ag
	7.5	4.5	16	23	49

MECHANISCHE WAARDEN	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
	As Welded		350		HRc

HERDROGEN Not required

MELTING RANGE 680 - 705°C

GAS ACC. EN ISO 14175