



# CEWELD L-Ag34Sn

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                                |                              |
|---------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|--------------------------------|------------------------------|
| TYPE                                              | High silver containing cadmium free brazing alloy.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                            |                                |                              |
| APPLICATIONS                                      | L-Ag30Sn is for brazing a weight range of different metals in maintenance and repair with excellent strength, Boiler making, tubing, cooling equipment etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                            |                                |                              |
| PROPERTIES                                        | The presence of tin improves the fluidity and is useful to increase the activity of the flux. Do not use this alloy above working temperatures of 200 °C. Flux/Paste: CEWELD Super-Flux                                                                                                                                                                                                                                                                                                                                                                                                                          |                            |                                |                              |
| CLASSIFICATION                                    | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 17672: Ag 134              |                                |                              |
| SUITABLE FOR                                      | Brazing: Steels, Copper, Copper alloys, Stainless steel, Nickel and Nickel alloys. Also suitable for dissimilar joints between these metals.                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                            |                                |                              |
| APPROVALS                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                                |                              |
| WELDING POSITIONS                                 | <div>PAPBPCPDPEPFPG</div> |                            |                                |                              |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | Cu<br>36                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Zn<br>28                   | Sn<br>2.5                      | Ag<br>34                     |
| MECHANICAL PROPERTIES                             | Heat Treatment<br>As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa)<br>450 | A5<br>(%)<br>Hardness<br>HRc |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                            |                                |                              |
| MELTING RANGE                                     | 630 - 730°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                            |                                |                              |
| GAS ACC. EN ISO 14175                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                                |                              |