CEWELD L-Ag27

certilas® THE FILLER METAL SPECIALIST

TYPE	Silver containing cadmium free brazing alloy
APPLICATIONS	Solder for typical base materials: hard metals and materials that are difficult to wet, such as tungsten, molybdenum, tantalum and chrome.
PROPERTIES	L-Ag27 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
CLASSIFICATION	EN ISO 17672: Ag 427
SUITABLE FOR	Brazing Tungsten tool tips, widia, and Molybdenum Alloys to steel
APPROVALS	
WELDING POSITIONS	

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Mn	Ni	Cu	Zn	Ag
9.5	5.5	38	20	27

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded		250		HRc

REDRYING	Not required
MELTING RANGE	680 - 830°C
GAS ACC. EN ISO 14175	