



CEWELD L-Ag49NiMn

TYPE	Silver brazing alloy for joining steel to Tungsten and other difficult to braze composites.				
APPLICATIONS	Typical base materials: Hard metal and materials that are difficult to wet, such as Tungsten, Molybdenum, Tantalum and Chrome.				
PROPERTIES	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				
CLASSIFICATION	AWS EN ISO		A 5.8: BAg-22 17672: Ag 449		
SUITABLE FOR	Brazing tungsten tool tips, diamont, widia, and molybdenum alloys to steel				
APPROVALS					
WELDING POSITIONS					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	Mn 7.5	Ni 4.5	Cu 16	Zn 23	Ag 49
MECHANICAL PROPERTIES	Heat Treatment As Welded	R _{P0,2} (MPa)	R _m (MPa) 350	A5 (%)	Hardness HRc
REDRYING	Not required				
MELTING RANGE	680 - 705°C				
GAS ACC. EN ISO 14175					