



# CEWELD L-Ag27

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                         |                      |        |          |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------|----------|
| 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 <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         | 250                  |        | HRc      |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                         |                      |        |          |
| MELTING RANGE                                     | 680 - 830°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |        |          |
| GAS ACC. EN ISO 14175                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                         |                      |        |          |