

CARBO L-Ag 40 Sn (F)

International standards	Material No.	2.5165
	DIN EN 1044	AG 105
	DIN 8513	L-Ag40Sn
	EN ISO 3677	B-Ag 40 CuZnSn-650-710

Typical applications and characteristics CARBO L-Ag 40 Sn is a silver brazing rod, which is free of cadmium. It is suitable for joints of steels, copper, bronze, brass and nickel alloys. The silver solders are available with and without flux-coating

Application hints: The base material should be clean of oxides, fat oil, grease and preferably be metallic blank. An additional flux suitable for the base material should be applied. For optimal penetration the base material sheets should be adjusted properly with an equal gap and must be heated up to the below shown melting temperature before infusing the brazing alloy.

Soldering instruction In normal cases a neutral flame adjustment is required, but on zinc-plated sheets and brass or depositing overlays light oxigen excess is optimal. After brazing flux-residues should be removed and the open end of the applied rod must be closed by hammering for avoiding uncontrolled reactions of out coming flux

Mechanical properties of all-weld metal (typical values)	Elongation l = 5 d	Density g/cm ³	Melting range Solidus Liquidus		Working temperatur
	20	9,1	650°C	710°C	690° C
	Tensile strength R_m N/mm² an St37 An St50				
	350 430				11 Sm/mm ²

The mecanical properties can be decreased by soldering of carbon steel

Analysis of pure deposit %	Ag	Zn	Sn	Si	Cu
	40	21	2	0,15	Rest

Dia. / Length	Pcs. / packet	Pcs. / carton	kg / 1000	kg / packet	kg / carton
1,0 x 500				1,0	
1,5 x 500				1,0	
2,0 x 500				1,0	
3,0 x 500				1,0	

Rev.000