Product Information

Silver hard solders L-Ag12, L-Ag20, L-Ag25

Silver hard solders with high-temperature resistance

**Ag 212, Ag 225 according to DIN EN ISO 17672,
AG 206 according to DIN EN 1044**

Item-No. 34 ….

New

With immediate effect we abstain from using environmental harmful colourants and deliver our silver hard solders with white flux coat and imprinted alloy, dimension and batch number.

Description

Cadmium-free silver hard solders with 12, 20 and 25 % silver, with high tensile strength (up to 300° C).

Ag 212, Ag 225 acc. to DIN EN ISO 17672, AG 206 acc. to DIN EN 1044,
B-Cu48ZnAg(Si), B-Cu44ZnAg(Si), B-Cu40ZnAg(Si) acc. to ISO 3677

Properties

Our cadmium-free silver hard solders are characterised by excellent flow properties and high tensile strength.

Alloy acc. to DIN 8513	Alloy acc. to DIN EN ISO 17672	Melting area	Working temperature	Tensile strength of the soldering point	Density
L-Ag12	Ag 212	800 - 830° C	830° C	400 N/mm²	8,5 g/cm³
L-Ag20	-	690 - 810° C	810° C	400 N/mm²	8,7 g/cm³
L-Ag25	Ag 225	700 - 790° C	780° C	400 N/mm²	8,8 g/cm³

Alloy (DIN EN 17672)	Composition (weight-%)		
	Ag	Cu	Zn
L-Ag12 (Ag 212)	12	48	40
L-Ag20 (-)	20	45	35
L-Ag25 (Ag 225)	25	41	34

Application

For the hard soldering of steel, malleable cast iron, copper, copper base alloys, nickel and nickel base alloys. For soldering on stainless steel we generally recommend a nickel containing solder like our L-Ag56InNi.

The soldering joints are applicable at a working temperature up to +300° C without reduction of the tensile strength. Bare material has to be soldered in combination with a flux according to DIN EN 1045 – FH 10 (“CuFe No. 1” paste resp. “CuFeP” powder).

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Application advices

Soldering parts must be free of oxide layers, tinder, dross, oil and greases. When using bare rods, apply sufficient flux on the soldering joint and surroundings. Heat the working piece up to working temperature, put soldering rod into position and let the solder run.

When using flux-coated solders, heat up work piece to 250° C, put soldering rod into position and let flux melt. Heat up to working temperature and let the solder melt. Adjust the flame of the soldering burner neutral up to light decreasing (gas surplus). The water-soluble flux residues have to be removed carefully.

Delivery forms

Delivery forms	Dimensions
500 mm rods 1 kg manufacturing rings Wire on spools	Ø 1,0 mm
	Ø 1,5 mm
	Ø 2,0 mm
	Ø 3,0 mm
Flux-coated rods acc. to DIN EN 1045	Ø 1,5 mm x 500 mm
	Ø 2,0 mm x 500 mm
	Ø 3,0 mm x 500 mm

Further advices

Felder cadmium-free silver hard solders do not contain any substances that are subject to restriction by directive 2011/65/EU (“RoHS”) above 0,1 weight-% (0,01 weight-% for cadmium) with regard to each homogenous material.

Store protected from moisture.

 Status: 10/15

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