

# Product Information

## Silver Brazing Alloy Ag 449 (L-Ag49)

For the soldering of carbide on steel

Brazing alloy Ag 449 acc. to DIN EN ISO 17672,  
B-AG49ZnCuMnNi 670/690 acc. to ISO 3677  
resp. L-Ag49-Cu acc. to DIN 8513

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All information about our products are the result of our long standing experience which we would like to pass on to our customers as application support. However, as we do not have any influence on the application of the works carried out with our products, please see the warranty claims in our conditions of sale because our liability is limited.

This product information does not constitute warranted properties.

## Description

Silver brazing alloy Ag 449 is suitable for the soldering of carbide on steel. It is a low-temperature melting solder for the reduction of tension for very different expansion coefficients of carbide and steel materials. The reachable strength of the joint patch depends on the strength of the basic materials. It can be used for all flame brazing processes and for induction heating. Typical application areas are to be found in e.g. in the tool manufacturing industry.

## Properties

<b>Metallic Composition:</b>	Ag49 Cu27.5 Zn20.5 Mn2.5 Ni 0.5
<b>Working temperature:</b>	approx. 690 °C
<b>Melting range:</b>	approx. 680 – 705 °C
<b>Shear strength acc.to DIN 8525:</b>	150 – 300 N/mm <sup>2</sup> (carbide on steel)
<b>Tensile strength:</b>	340 N/mm <sup>2</sup>
<b>Density:</b>	8.9 g/cm <sup>3</sup>
<b>Operating temperature of the soldering point:</b>	max. 200°C (without loss of strength)

## Application Advices

Remove solder joints from oxide layers, scale, slags, oils and fats. For brazing you need a flux according to DIN EN 1045, FH 12. We recommend our **FELDER "CuFe Nr. 1 - Spezial"**. The flux is applied to the solder joint and the immediate environment prior to soldering. Set the flame of the oxy-acetylene torch neutral to slightly reducing (gas excess). Heat workpiece to working temperature (690 °C), set up the hard solder rod and let it run. The flux residues are to be removed carefully, these are water-soluble. Of course, the FELDER Ag 449 can also be processed with other heating methods, such as induction or in a soldering oven.

## Delivery Forms

Delivery form	Available Diameters
500 mm rods	Ø 1.0 mm
1 kg manufacturing rings	Ø 1.5 mm
Wire on spools	Ø 2.0 mm
	Ø 3.0 mm

## Further Advices

Store protected from humidity.