

**CARBIDE AND DIAMOND TIPPED TOOLS
 HARTMETALL- UND DIAMANTWERKZEUGE**

BRAZING ALLOYS WITH SILVER

HARTLOTE MIT SILBER

| Code Artikel | Composition % Zusammensetzung % | | | | | | | Melt. range Schmelz B. °C | Density Dichte | Tensile strength Zugfestig keit Kg/mm ² | Corresponding standard Normung | | |
|---|------------------------------------|------|------|----|----|-----|-----|------------------------------------|-------------------|--|-----------------------------------|---------|----------------|
| | Ag | Cu | Zn | Cd | Sn | Ni | Mn | | | | DIN 8513 | BS 1845 | AWS A5.8.89 |
| | Ag55Sn | 55 | 21 | 22 | | 2 | | | | | | 630-660 | 9,4 |
| Ag50Ni | 50 | 20 | 28 | | | 2 | | 660-750 | 9,0 | 45 | | | B Ag-24 |
| Ag50Cd | 50 | 15 | 17 | 18 | | | | 620-640 | 9,5 | 43 | L-Ag50Cd | AG 1 | B Ag-1a |
| Ag50CdNi | 50 | 15 | 16 | 16 | | 3 | | 635-690 | 9,5 | 45 | L-Ag50CdNi | AG 9 | B Ag-3 |
| Ag49MnNi | 49 | 16 | 23 | | | 4,5 | 7,5 | 625-705 | 8,9 | 55 | L-Ag49 | AG 18 | B Ag-22 |
| Ag44 | 44 | 30 | 26 | | | | | 670-730 | 9,1 | 51 | L-Ag44 | AG 15 | B Ag-15 |
| Ag42Cd | 42 | 17 | 16 | 25 | | | | 605-620 | 9,4 | 42 | | AG 2 | |
| Ag40Cd | 40 | 19 | 21 | 20 | | | | 595-630 | 9,3 | 42 | L-Ag40Cd | AG 10 | |
| Ag20 | 20 | 46 | 34 | | | | | 690-810 | 8,7 | 43 | L-Ag20 | | |
| COPPER SANDWICHED ALLOYS / SCHICHTLOTE | | | | | | | | | | | | | |
| Ag50CdNi TR | 50 | 15 | 16 | 16 | | 3 | | 635-690 | | | | | |
| Ag49MnNi/1 TR | 49 | 27,5 | 20,5 | | | 0,5 | 2,5 | 670-690 | | | | | |

CHARACTERISTIC MAKE-UP / LIEFERFORMEN

| | | |
|--------------------------------------|-----------------------------------|---|
| Rods / Stäbe: | Ø 0,7 ... 3 mm | Lenght / Länge: 500 mm |
| Coated Rods / Umhüllte Stäbe: | Ø 1,5 - 2 - 3 mm | Lenght / Länge: 500 mm |
| Wires / Drähte: | Ø 0,3 ... 3,0 mm | (rings and spools / Strangen und Spulen) |
| Strips / Bänder: | Thickness / Dicke: 0,1 ... 1 mm | Width / Breite: 2...60 mm |
| Sandwiched coils / Schichtbänder: | Thickness / Dicke: 0,2 ... 0,8 mm | Width / Breite: 2...80 mm |
| Powder and Paste / Pulver und Pasten | | |
| Rings / Ringe | | |

FLUXES FLUßMITTEL

| Code Artikel | Operating range Wirktemperatur °C | Powder Pulver | Paste Paste | Standard Normung DIN 8511 | Applications Anwendungen |
|-----------------|---|------------------|----------------|---------------------------------|---|
| FLUX AG4 | 550-850 | X | X | F - SH1 | General purpose - Wide range of temperature Allgemein verwendung. Weit Schmelzbereich |
| FLUX AG7 | 500-800 | | X | F - SH1 | For stainless steel Für nichtrostende Stahl |
| FLUX AG8 | 500-800 | | X | F - SH1 | For stainless steel and hard metals Für nichtrostende Stahl und Hartmetall |
| FLUX AG11 | 500-800 | | X | F-SH1 | Dispensable paste, same application as FLUX A7 Dosierfähige Paste, Anwendung wie FLUX A7 |
| FLUX AG12 | 500-800 | | X | F-SH1 | Dispensable paste, same application as FLUX A8 Dosierfähige Paste, Anwendung wie FLUX A8 |

The above data are subjected to change without notice.

Änderungen vorbehalten