

## Flux coated cadmium free silver brazing, low temperature, high capillary

### CLASSIFICATION

EN ISO 17672 (AG 155)  
EN 1044 (AG 103)

### GENERAL DESCRIPTION

Flux coated, cadmium free silver alloy, high silver content, for capillary brazing.  
Low melting point, exceptional flowing and high capillarity.  
For joining stainless steel, copper alloys, nickel alloys, cast iron and steel.  
High corrosion resistance, seawater resistant, outstanding flowing and wetting properties.  
Good colour match with stainless steel.  
Operating temperature, up to about 200 °C.  
Melting range: 620 - 660 °C. (working temperature 650 °C)

### TYPICAL USE

Piping for gas, water, lubricants and pressure.  
Machine parts, electrical contacts, refrigeration, plumbing, air conditioning.  
Food, beverage and dairy industry, pharmaceutical industry, cookware and cutlery.

Lastek B3055V is cadmium free and applies to the European RoHS guideline and the European cadmium guideline.

### CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Cu	Ag	Zn	Sn	Si		
20.0 - 22.0	54.0 - 56.0	20.0 - 24.0	1.5 - 2.5	0.05 - 0.20		

### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
0	450 MPa	0	0

### General information

**Welding positions:** NA

**Shielding gas:** NA

**Dia (x length) (mm):** 1.5 - 3.0 (x 500)

**Packing:** 1 kg in cardboard box (6 boxes in one pack)

**Polarity:** NA

**Tips & tricks:** Joint preparation: optimum clearances 0.05 to 0.15 mm.  
Preheat the work piece slightly with neutral flame.  
Rub the coated rod along the joint to apply the flux. As soon as the flux is flowing, melt the rod.  
Continue heating until the alloy flows into the entire joint by capillarity.  
Cool down and remove flux residues by brushing with hot water.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.