

Lastek B3025

Cadmium free silver brazing, large joints

CLASSIFICATION

EN ISO 17672 : AG 125

EN 1044 : AG 108

GENERAL DESCRIPTION

Cadmium free silver alloy, moderate silver content. Good flowing characteristics and sufficient capillarity, so suitable for joints with large clearances.

For joining mild and low alloyed steel, stainless steel, copper alloys, nickel alloys.

Operating temperature, up to about 300 °C. // Melting range: 680-760 °C.

Lastek B3025 is cadmium free and applies to the European RoHS guideline and the European cadmium guideline.

APPLICATIONS

Machine parts for food and beverage industry.

Mechanical and electrical industry.

Heat exchangers.

Lastek B3025 is also available as coated rod Lastek 3025V.

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

Cu : 39.00 - 41.00	Ag : 24.00 - 26.00	Zn : 31.00 - 35.00	Sn : 1.50 - 2.50	
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MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	350 - 450 MPa		

GENERAL INFORMATION

Welding positions NA

Shielding gas NA

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

Polarity NA

Diameter (mm) 1.5 2.0 3.0

Length (mm) 500 500 500

Tips & tricks

Joint preparation: optimum clearances 0.05 to 0.20 mm.

Preheat the work piece slightly with neutral flame. Preheat the brazing rod slightly and dip it into the flux. The flux will adhere to the rod. Rub the 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.

Powder flux: Lastek 31C (general work) or Lastek 31CH (higher temperatures, e.g. large work pieces in red copper).

Paste flux: Lastek 31CN (general work) or Lastek 31CNB (stainless steel, hard metals and induction brazing).

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.