PRODUCT SPECIFICATION

Lastek B3025 V

Flux coated cadmium free silver brazing, large joints

CLASSIFICATION

EN ISO 17672 : AG 125
EN 1044 : AG 108

GENERAL DESCRIPTION

Flux coated, 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 B3025V 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.

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	

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
NPD	350 - 450 MPa	NPD	NPD

GENERAL INFORMATION

Welding positions	PA, PB	
Shielding gas	NA	
Packing	1 kg in a cardboard box	
Polarity	NA	
Diameter (mm)	1.5	500
Lenght (mm)	500	3.0
Approx. current (A)	2.0	500

Tips & tricks

Joint preparation: optimum clearances 0.05 to 0.20 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.