

# Lastek B3055

Cadmium free silver brazing, low temperature, high capillary

## CLASSIFICATION

EN ISO 17672 : AG 155

EN 1044 : AG 103

## GENERAL DESCRIPTION

Cadmium free silver alloy with 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: 630 - 660 °C. (working temperatur 650 °C).

Lastek B3055 is cadmium free and applies to the European RoHS guideline and the European cadmium guideline.

## APPLICATIONS

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 B3055 is also available as coated rod Lastek B3055V.

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

<b>Cu</b> : 20.00 - 22.00	<b>Ag</b> : 54.00 - 56.00	<b>Zn</b> : 20.00 - 24.00	<b>Sn</b> : 1.50 - 2.50	
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## 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)
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 2.0 3.0

**Lenght (mm)** 500 500 500

### Tips & tricks

Joint preparation: optimum clearances 0.05 to 0.15 mm.

Preheat the work piece slightly with neutral flame and also preheat the brazing rod slightly and dip it into the flux. The flux will stick 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.