

# Lastek 12

## Brazing rod for steel, maximum strength

### CLASSIFICATION

ISO 3677 : B-Cu50ZnNiAg - 860/890

### GENERAL DESCRIPTION

Flux coated brazing rod containing silver, for joining steel, cast iron, copper, nickel alloys and hard metals.  
 Very high tensile strength.  
 Superior wetting action produces thin and smooth fillets with little or no finishing required.  
 Allows minimum joint preparation.  
 Ideal for carbide tipping.

### APPLICATIONS

Steel tubing, machine parts, frames of bicycles.  
 Metallic furniture, medical apparatus.  
 Construction and repair of tools and dies.

Hardness: 180 - 200 HB.  
 Bonding temperature: 860 - 900 °C.  
 Working temperature: 850 °C.

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

<b>Ag :</b> 1.00	<b>Cu :</b> 50.00	<b>Zn :</b> 40.00	<b>Si :</b> 0.15	<b>Ni :</b> 9.00
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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)
	800 MPa	≥ 20%	

### GENERAL INFORMATION

<b>Welding positions</b>	NA		
<b>Shielding gas</b>	NA		
<b>Packing</b>	5 kg in a cardboard box		
<b>Polarity</b>	NA		
<b>Diameter (mm)</b>	2.0	3.0	4.0
<b>Length (mm)</b>	500	500	500

**Tips & tricks**

- Clean the weld areas.
- Preheat with neutral flame until dark-red.
- Apply Lastek 12 so that it penetrates into the joint.
- A separate flux, Lastek 12A, applied on the working area, can still improve the penetration.

*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.*