PRODUCT SPECIFICATION

Lastek 38

Silver solder for copperalloys

CLASSIFICATION

EN 1044 : CP 102
AWS A5.8 : B CuP-5

GENERAL DESCRIPTION

Very good bond on copper, brass and bronze.
No flux needed on pure copper.
Very economic use due to the high capillary flow and excellent fluidity.

APPLICATIONS

Joining of copper in machine construction, electric motors, hydraulic lines.
Joints in refrigeration installations.

Hardness: 180 HB
Bonding temperature: 680°C (1256°F)
Electrical resistivity: 0.14 ohm.mm²/m (0.00001 ohms/in/in²)

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

Ag : 14.50 - 15.50	**P :** 4.70 - 5.30	**Cu :** Balance		

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 250 MPa	≥ 10%	

GENERAL INFORMATION

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

Tips & tricks

Joint clearances: 0.2mm (0.008") or less.
On pure copper no flux is needed.
Apply flux Lastek 31C (powder) or Lastek 31CN (paste) on brass and bronze.
Lastek 38 is not suitable for Ni or Al alloys, or for steels.