

Lastek 38

Silver solder for copper alloys

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		
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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)
	≥ 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

Length (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.

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.