

# Lastek 38 B

## Very thin flowing silver alloy

### CLASSIFICATION

EN ISO 17672 : CuP 279

AWS A5.8 : B CuP-6

### GENERAL DESCRIPTION

Recommended for joining all non-ferrous metals, except nickel and aluminium.

Requires no flux on copper, eliminating cleaning problems after brazing.

On brass and bronze, to be used with flux.

Do not use on steel.

### APPLICATIONS

Brazing of electrical contacts.

Soldering of copper tubes, cold and hot water installations, heating elements.

!! Do not use for brazing tubes with sulphur containing oils. !!

Hardness: 180 HB

Bonding temperature: 690 °C (1270°F)

Electrical resistivity: 0.25 ohm.mm<sup>2</sup>/m (0.00001 ohms/in<sup>2</sup>)

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

<b>Ag</b> : 1.50 - 2.50	<b>P</b> : 5.90 - 6.70	<b>Cu</b> : Balance		
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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)
	≥ 250 MPa	≥ 5%	

### GENERAL INFORMATION

**Welding positions** NA

**Shielding gas** NA

**Packing** 1 kg in a cardboard box

**Polarity** NA

**Diameter (mm)** 2.0 3.0

**Length (mm)** 500 500

#### Tips & tricks

Brazing gap: up to 0.5 mm (0.02").

Clean joint area thoroughly and heat the complete joint with a slightly carburizing flame.

When the parent metal is pure copper, you can apply the brazing rod directly.

On brass use flux Lastek 31C (powder), 31CH (powder for thicker pieces) or 31CN (paste).

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.