PRODUCT SPECIFICATION

Lastek B3045

Cadmium free silver brazing, general purpose

CLASSIFICATION

EN ISO 17672 : AG 145
EN 1044 : AG 104

GENERAL DESCRIPTION

Cadmium free silver alloy, high silver content, for capillary brazing. Excellent flowing characteristics and capillarity. Low melting point, for general use.
For joining copper and copper alloys, nickel and nickel alloys, malleable cast iron and steel. Thanks to the low melting point very suitable for brazing of dissimilar metals. High corrosion resistance and seawater resistant.
Operating temperature, up to about 200 °C. // Melting range: 640-680 °C. (working temperature 670 °C).

Lastek B3045 is cadmium free and applies to the European RoHS guideline and the European cadmium guideline.

APPLICATIONS

Machine parts for food, beverage, dairy and pharmaceutical industries.
Plumbing, piping, air treatment and conditioning.
Automotive and electrical and electronics industry.
Cookware.

Lastek B3045 is also available as coated rod Lastek B3045V.

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

Cu : 26.00 - 28.00	**Ag :** 44.00 - 46.00	**Zn :** 23.50 - 27.50	**Sn :** 2.00 - 3.00	

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	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).