

# Lastek B3040 V

Flux coated cadmium free silver brazing, good flowing

## CLASSIFICATION

EN ISO 17672 : AG 140

EN 1044 : AG 105

## GENERAL DESCRIPTION

Flux coated, cadmium free silver alloy, high silver content, good flowing properties and capillary.

For tougher joints and high strength.

Seawater resistant.

Joining unalloyed and low alloy steel, stainless steel, copper alloys, nickel alloys, cast iron.

Operating temperature, up to about 200 °C. // Melting range: 650-710 °C.

Lastek B3040V is cadmium free and applies to the European RoHS guideline and the European cadmium guideline.

## APPLICATIONS

Machine parts for food and beverage industry.

Dairy and pharmaceutical industries.

Breweries and dairies.

Bronze and brass fittings.

Plumbing, piping, refrigeration, air treatment, instruments.

Cookware.

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

<b>Cu</b> : 29.00 - 31.00	<b>Ag</b> : 39.00 - 41.00	<b>Zn</b> : 26.00 - 30.00	<b>Sn</b> : 1.50 - 2.50	
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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)
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

**Length (mm)** 500 500 500

### Tips & tricks

Joint preparation: optimum clearances 0.05 to 0.15 mm.

Preheat the work piece slightly with neutral flame. Rub the coated 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.

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.