

International standards	Material No.	2.1210
	EN 1044	CP 102
	DIN 8513	L-Ag15P

Approvals ---

Typical applications and characteristics CARBO L-Ag15P is suitable for the flux free soldering of copper tube pipes as follows:
Gas / Gas liquid / cold and warm water / oil / climate and heating units.
For the soldering of brass and red brass you have to use additionally hard solder flux according to DIN EN 1045 – FH 10.
The solder should not be used with sulpherous materials.
This solder is not suitable for the soldering of steel and high-grade steels.
The following silver solders are suitable for steel:
DIN EN 1044 – Ag 106 - L-Ag34Sn (DIN 8513)
DIN EN 1044 – Ag 203 - L-Ag44 (DIN 8513)
DIN EN 1044 – Ag 104 - L-Ag45Sn (DIN 8513)
The following silver solders are suitable for high grade steel:
DIN EN 1044 – Ag 403 - L-Ag56InNi (DIN 8513)

Soldering instruction The flame adjustment depends on the thickness of the base material
After brazing flux-residues should be removed and the open end of the applied rod must be closed by hammering for avoiding uncontrolled reactions of out coming flux
The silver solders are available with and without flux-coating

Mechanical properties of all-weld metal (typical values)	Working Temp: °C	Solidus °C	Liquidus °C	Density g/cm ³	Tensile strength R _m N/mm
	710	650	800	8,4	250

Dia. / Length	Pcs. / packet	Pcs. / carton	kg / 1000	kg / packet	kg / carton
1,5 x 500				1,0	25,0
2,0 x 500				1,0	25,0
3,0 x 500				1,0	25,0

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