

Silver solder for copper alloys**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 Modi Lastek 31C (powder) or Modi Lastek 31CN (paste) on brass and bronze.
 Modi Lastek 38 is not suitable for Ni or Al alloys, or for steels.