

Lastek 38

Silver solder for copper alloys

CLASSIFICATION

EN 1044 (CP 102)
AWS A5.8 (BCuP-5)

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.

TYPICAL USE

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	P	Cu				
14.50 - 15.50	4.70 - 5.30	Balance				

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: NA

Shielding gas: NA

Dia (x length) (mm): 2.0 - 3.0 (x 500)

Packing: 1 kg in a cardboard box

Polarity: NA

Tips & tricks: Joint clearances: 0.2mm (0.008") or less.
On pure copper no flux is needed.
Apply flux Lastek 31C (powder) or Lastek 31CN (paste) on brass and bronze.
Lastek 38 is not suitable for Ni or Al alloys, or for steels.

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.