

UTP Trifolie

Standards :

EN 1044	: AG 502
DIN 8513	: L-Ag 49
EN ISO 3677	: BAg49ZnCuMnNi680-705

Laminated solder with 49 % Ag and copper-middle layer for hardmetals, cadmium-free

Application field

UTP Trifolie is a laminated high silver containing solder for brazing of wear-resistant sheets on unalloyed steel, especially for stress-sensitive tools. Good wettability.

Heating sources

Acetylene torch, oven, HF-induction

Technical data

Working temperature	Shear strength
° C	R_m MPa
690	150 - 300

The shear strength depends on the Co-content of the hard metal.

Weld metal analysis in %

Mn	Ni	Cu	Zn	Ag
2,5	0,5	25,0	balance	49,0

Instructions

Clean solder joint thoroughly, apply UTP flux on solder joint. Large weldments must be preheated right through until flux flows like water. Place rod onto groove, melting off a small droplet which is spread out or drawn along with the flame.

Flame adjustment

Acetylene torch (excess fuel gas)

Availability

Brazing foil	Ø mm x 70,0 mm	0,2*	0,3*	0,4*
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* available on request

Fluxes

UTP Flux AGF-S	Universal silver-solder-flux in paste form
UTP Flux AGX	Universal silver-solder-flux in powder form
UTP Flux 3 W	Universal silver-solder-flux in powder form with increased resistance to high temperatures