

## Technical Data Sheet BrazeTec Cu/NiN

### Standard

ISO 17672	Cu 110
(DIN EN 1044)	(CU 101)
(US-Standard ANSI/AWS A5.8)	(BCu-1)

### Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]	Cu min. 99.90 (brazing alloy layer)
Max. impurities [wt.-%]	max. 0.04 (without O and Ag)

### Technical data

Melting range	approx. 1085 °C
Working temperature	approx. 1100 °C
Density	approx. 8.9 g/cm <sup>3</sup>
Shear strength acc. DIN EN 12797	200 - 300 MPa (carbide/steel)
Operating temp. of brazed joint	max. 300 °C (without loss in strength)

### Standard delivery forms\*

Ribbon:	0.35 mm thickness and 70 mm width
Preforms:	stamped and shaped parts, shims, discs, perforated plates

\*Other delivery forms upon request

### Applications

BrazeTec Cu/NiN is a brazing alloy with a nickel net interlayer to compensate the internal stresses. The brazing alloy is suitable for brazing of cemented carbides to steel. The reachable strength of the joint depends from the parent metals.

It is well suitable for brazing under protective atmosphere or under vacuum.

Typical applications are found e.g. in the tool industry.

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