

Technical Data Sheet BrazeTec 49/Cu

Standard

BrazeTec Standard
 ISO 3677 B-Ag49CuZnMnNi 670/690

Nominal composition [wt.-%] (brazing alloy layer) Ag 49; Cu 27.5; Zn 20.5; Mn 2.5; Ni 0.5
Permitted impurities max. [wt.-%] Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
max. impurities [wt.-%] 0.3

Technical data

Melting range approx. 670 - 690 °C
Working temperature approx. 690 °C
Density approx. 9.0 g/cm³
Shear strength acc. DIN EN 12797 150 - 300 MPa (carbide/steel)
Operating temp. of brazed joint max. 200 °C (without loss in strength)

Standard delivery forms*

Ribbon: 0.2/ 0.3/ 0.4 mm thickness and 70 mm width
Preforms: discs, sections, shaped parts
 *Other delivery forms upon request

Applications

BrazeTec 49/Cu is a low melting silver based brazing alloy with copper interlayer to compensate the internal stresses of the joint. The brazing alloy is suitable for brazing of cemented carbides to steel. The reachable strength of the joint depends from the parent metals. It can be used for brazing with flame or induction brazing procedures. Typical applications are found e.g. in the tool industry.

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