

Technical Datasheet BrazeTec 49/Cu plus

Standard

BrazeTec Standard
(ISO 3677)

(B-Ag49CuZnMnNi 670/690)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

(brazing alloy layer) Ag 49; Cu 27.5; Zn 20.5; Mn 2.5; Ni 0.5
Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
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

200 - 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 plus is a low melting silver based brazing alloy with modified 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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