

Technical Data Sheet BrazeTec 60/40

Standard

ISO 17672
(DIN EN 1044)

Cu 670
(CU 303)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]
Max. impurities [wt.-%]

Cu 60; Si 0.3; Mn 0.15; Zn rem.
Al 0.01; As 0.01; Bi 0.01; Cd 0.01; Fe 0.25; Pb 0.02; Sb 0.01;
0.2; Sn 0.1;

Technical data

Melting range	approx. 870 - 900 °C
Working temperature	approx. 900 °C
Density	approx. 8.4 g/cm ³
Shear strength acc. DIN EN 12797	approx. 150 - 300 MPa
Elongation	approx. 35 %
Electrical Conductivity	approx. 15.5 m/ Ωmm ²
Operating temp. of brazed joint	max. 300 °C (without loss in strength)

Standard delivery forms*

Wire:	1.5 - 2.0 - 3.0 mm Ø
Rods:	1.5 - 2.0 - 3.0 mm Ø, 500 mm length
Ribbon:	0.1/ 0.2/ 0.3/ 0.4 mm thickness and 70 mm width
Preforms:	rings, shaped parts, sections

*Other delivery forms upon request

Applications

BrazeTec 60/40 is a brazing alloy with good flow characteristics. It can be used for brazing any steels, copper as well as for nickel and nickel based alloys. In special cases BrazeTec 60/40 can be used for brazing cemented carbides.

It can be used for brazing with flame or induction brazing procedures.

Typical applications are found e.g. in automotive and in the electric and tool industry.

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