

TD-TM-BT-0058-E-00

Standard

BrazeTec Standard
ISO 3677

B-Cu39AgZnMnInNi-680/760

Nominal composition [wt.-%]

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

(brazing alloy layer) Cu 39; Ag 28; Zn 20; Mn 10; In 2; Ni 1
Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
0.3

Technical data

Melting range acc. Measurement
Brazing temperature
Density
Shear strength*
Operating temp. of brazed joint

approx. 680 - 760 °C (DSC-measurement)
min. 710 °C
approx. 8.7 g/cm³
> 180 MPa (carbide/steel)
max. 200 °C (without loss in strength)

Standard delivery forms

Ribbon:
Preforms:

0.25/ 0.3/ 0.4 mm thickness; other dimensions upon request
Upon request

Applications

BrazeTec 28/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.

*Measured according to BrazeTec standard (AA-TM-BT-6013-D-00): Parent materials: 1.2210 & K10

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