

Technical Data Sheet BrazeTec D 804.1

Standard

BrazeTec Standard
(ISO 3677)

(B-Cu87MnNi-980/1020)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Cu Rem.; Mn 10.0; Ni 3.0

Cd 0.010; Pb 0.025

Technical data

Melting range of brazing alloy

approx. 970 - 1030 °C

Optimum brazing temperature

approx. 1080 °C

Density of brazing alloy

approx. 8.75 g/cm³

Density of brazing paste

approx. 3.7 g/cm³ (20 °C)

Viscosity

550 - 650 dPa s (Haake Viscotester VT 02, Sp.2, 20 ±2 °C)

Cleaning agent

Water

Shelf life

min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30°C. stir well before use

Packaging

Standard

1; 5; 20 kg

Applications

BrazeTec D 804.1 is a dispensable, flux free copper based brazing paste with a high metal content. The paste adheres well on the part and dries very slowly at ambient temperatures.

The brazing alloy shows good flowing and wetting properties. Shear strength values up to 300 MPa can be obtained for cemented carbides - steel joints.

The dew point of the brazing atmosphere should be below - 40 °C to avoid oxidation of the contained manganese.

Due to the vapor pressure of the manganese the alloy should be used only in exceptional cases in vacuum processes.

Due to relative weak deformation behavior of the alloy the paste should not be used for highly stressed steel joints.

The paste can be used in protective atmosphere furnaces on cemented carbides, any steels, tungsten, tantalum and their alloys.

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

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