



## Brazing alloy BrazeTec 21/68

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	87	-	-	-	-	10	-	3 Co	-	-	-

### Technical data:

Melting range (°C)	990 - 1030
Working temperature (°C)	1020
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm <sup>2</sup> )	-
Elongation %	-
Density (g/cm <sup>3</sup> )	8,8
Shear strength (MPa)	200 - 300
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	300

### Applications

Tool industry

### Operating conditions

Copper based alloy with excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing cemented carbides, steel, nickel and nickel alloys. It is mainly used with furnace under protective atmosphere, due to the high working temperature. Free from Zn.

### Recommended fluxes

H spezial, H 285, S spezial

### Heat sources

Induction heating, furnace in vacuum or under protective atmosphere

### Delivery forms

Wire, rings

### Notes

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