



Brazing alloy BrazeTec 21/80

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	Rest	-	-	-	-	12	2	-	Cu 595	-	-

Technical data:

Melting range (°C)	965-1000
Working temperature (°C)	990
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	8,8
Shear strength (MPa)	200-300
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	-

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, ring

Notes

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