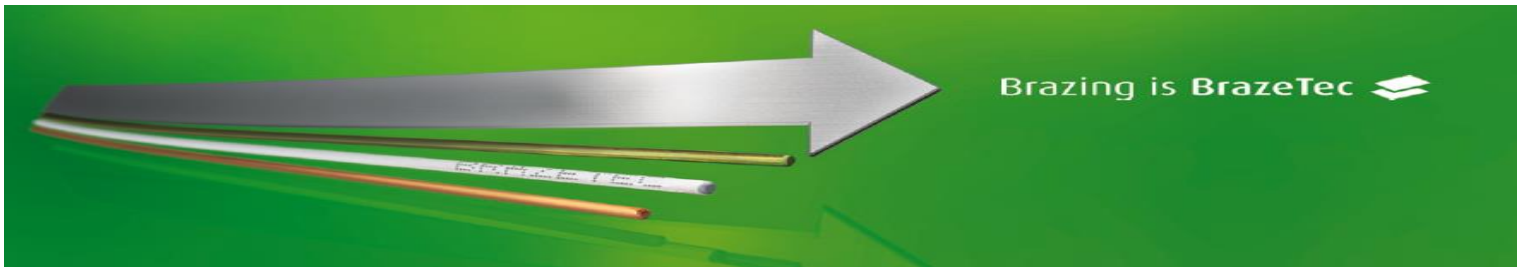
TECHNICAL DATASHEET



Brazing alloy BrazeTec BlueBraze 28/Cu

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
28	39	20	-	-	-	10	1	2 In	-	-	B-Cu39AgZnMnInNi-680/760

Technical data:

Melting range (°C)	-
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	680-760
Min. brazing temperature (°C)	710
Electrical conductibility (m/Ω mm²)	-
Elongation %	-
Density (g/cm^3)	8,7
Shear strength (MPa)	*>150(carbide/steel)
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	200

Applications
Tool industry

Operating conditions
Silver based brazing alloy with copper interlayer to compensate the internal stresses of the joint. Excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing of cemented carbides and steel. Thereachable strength of the joint depends from the parent metals.

Recommended fluxes
H spezial, H 285

Heat sources
Flame, induction heating

Delivery forms
Tri-foil: ribbon, preforms

Notes
*measured according to Brazetec standard(AA-TM-BT-6013-D-00): parent materials: 1.2210&K10

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