



## Brazing alloy BrazeTec BlueBrazo 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 conductivity (m/Ω mm <sup>2</sup> )	-
Elongation %	-
Density (g/cm <sup>3</sup> )	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

The information reported in this document about our products and equipment as well as our systems and procedures are based on our research and our experience in the field of applied engineering and are merely recommendations. Italbras S.p.A. cannot foresee all circumstances in which these information and our products will be used, therefore the user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. Italbras S.p.A. declines any liability for any loss, damage or injury howsoever arising (including any claim brought by third parties) as a result of the use of such information. Each warranty of suitability of our products and their use within the production processes of the user, must be agreed in written form. We reserve the right to make technical modifications to this document in the course of our product development.

### Italbras S.p.A.

Strada del Balsego, 6 – 36100 Vicenza (I)  
[info@italbras.it](mailto:info@italbras.it) - [www.italbras.it](http://www.italbras.it) -  
 Tel. +39 0444.3475-00 / Fax +39 0444.3475-01