



## Brazing alloy BrazeTec BlueBraze 28/Cuplus

### 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)	*>180(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. Mechanical strength improved of 20% compared to 28Cu alloy. Suitable for brazing of cemented carbides and steel. The reachable 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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