



Brazing alloy BrazeTec BlueBraze 2810

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 ²)	-
Elongation %	-
Density (g/cm ³)	8,5
Shear strength (MPa)	*>250(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 excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing of cemented carbides and materials which are difficult to wet. The reachable strength of the joint depends from the parent metals.

Recommended fluxes

H spezial, H 285, H paste, H 280, H 80

Heat sources

Induction heating, flame

Delivery forms

Wire, rods, ribbon, rings, preforms

Notes

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

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Italbras S.p.A.

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