



Brazing alloy BrazeTec 49/Cu 17

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
49	27,5	20,5	-	-	-	2,5	0,5	-	-	-	-

Technical data:

Melting range (°C)	670 - 690
Working temperature (°C)	690
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	9
Shear strength (MPa)	150 - 300
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	-

Applications

Tool industry

Operating conditions

Silver based brazing alloy. Partially increased 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.

Recommended fluxes

H spezial, H 285

Heat sources

Flame, induction heating

Delivery forms

Tri-foil: ribbon, preforms

Notes

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