



Brazing alloy BrazeTec 49/Cu

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) | 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.

Recommended fluxes

H spezial, H 285

Heat sources

Flame, induction heating

Delivery forms

Tri-foil: ribbon, preforms

Notes

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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