ITALBRAS®

TECHNICAL DATASHEET

Brazing alloy in paste BrazeTec CB 11

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
90	-	-	-	-	-	-	-	10 Ti	-	-	B-Ag90Ti 970

Technical data:

Melting range (°C)	970
Working temperature (°C)	1000-1050
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	360-400 to 1 bar
Flash point (°C)	105
Operating temperature of brazed joint (°C)	-
Tensile strength DIN EN 12797 (MPa)	-
Alloy density (g/cm^3)	-
Paste density (g/cm^3)	3,3
Metal content (%) of total weight	85
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	1,4-2 (Cone-Plate; 150 µm; D=50/s; 20 °C)
Cleaning agent	Braze Tec Agent P
Flux type within the paste	-
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

Applications
Tool industry, special applications

Operating conditions
Silver based brazing alloy, Ti activated, used for high temperature brazing of ceramics, ceramic-metal joints, grafite and diamonds. We recommend a minimum brazing temperature of 1000° C for ceramic joints. Higher brazing temperatures improve the brazing alloy behaviour.

Heat source
Brazing atmospheres in pure argon (4.8 or 99.998% purity) or in vacuum (app. 5 x 10-4 mbar). In case of brazing in vacuum the temperature should not exceed 900 °C to avoid silver evaporation. Active brazing alloys do not flow on ceramics, therefore always have to be applied on the entire surface to be brazed.

Standard packaging
Jar

Note
The mesh opening of screen printing fabrics should be between 150 and 220 mesh.

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