



## Brazing alloy BrazeTec CB 2

### Composition (% in weight)

| Ag | Cu | Zn | Sn | Si | P | Mn | Ni | Other | ISO 17672 | EN 1044:1999 | ISO 3677 |
|----|----|----|----|----|---|----|----|-------|-----------|--------------|----------|
| 96 | -  | -  | -  | -  | - | -  | -  | 4 Ti  | -         | -            | -        |

### Technical data:

|  |           |
|--|-----------|
| Melting range (°C)                                     | 970       |
| Working temperature (°C)                               | 1000-1050 |
| Melting range according to DSC measurement (°C)        | -         |
| Min. brazing temperature (°C)                          | -         |
| Electrical conductivity (m/Ω mm <sup>2</sup> )         | -         |
| Elongation %   | -         |
| Density (g/cm <sup>3</sup> )                           | 10,3      |
| Shear strength (MPa)                                   | -         |
| Tensile strength DIN EN 12797 (MPa)                    | -         |
| Operating temperature of brazed joint (min/max) ± (°C) | -         |

### Applications

Tool industry, special applications

### Operating conditions

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

### Recommended fluxes

-

### Heat sources

The brazing process has to be carried out in vacuum or with argon (4.8 or purity 99,998%) as protective atmosphere. If the brazing process is carried out in vacuum the brazing temperature should not be higher than 1000 °C to prevent silver from evaporating (if argon is used a brazing temperature of 1050 °C is possible). Active brazing alloys do not flow on ceramics, therefore always have to be applied on the entire surface to be brazed.

### Delivery forms

Wire, ribbon, rings, preforms

### Notes

-

The information reported in this document about our products and equipment as well as our systems and procedures are based on our research and our experience in the field of applied engineering and are merely recommendations. Italbras S.p.A. cannot foresee all circumstances in which these information and our products will be used, therefore the user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. Italbras S.p.A. declines any liability for any loss, damage or injury howsoever arising (including any claim brought by third parties) as a result of the use of such information. Each warranty of suitability of our products and their use within the production processes of the user, must be agreed in written form. We reserve the right to make technical modifications to this document in the course of our product development.

### Italbras S.p.A.

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