



## Brazing alloy BrazeTec CB 4

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
70,5	26,5	-	-	-	-	-	-	3 Ti	-	-	-

### Technical data:

Melting range (°C)	780-805
Working temperature (°C)	850-950
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> )	9,9
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. A minimum brazing temperature of 850 °C is recommended for ceramic joints. Higher brazing temperatures improve the brazing alloy behaviour.

### Recommended fluxes

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### 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 900 °C to prevent silver from evaporating. 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

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### 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