



Brazing alloy BrazeTec CB 5

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
64	34,2	-	-	-	-	-	-	1,8 Ti	-	-	-

Technical data:

Melting range (°C)	780-810
Working temperature (°C)	850-950
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	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 - www.italbras.it -
 Tel. +39 0444.3475-00 / Fax +39 0444.3475-01