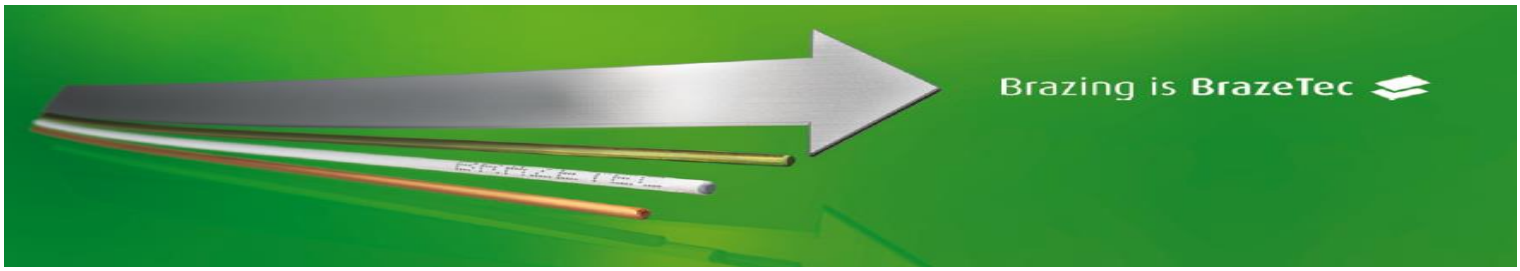
TECHNICAL DATASHEET



Brazing alloy BrazeTec Cu/NiN

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	100	-	-	-	-	-	-	-	-	-	-

Technical data:

Melting range (°C)	app. 1085
Working temperature (°C)	app. 1100
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductibility (m/Ω mm²)	-
Elongation %	-
Density (g/cm^3)	8,9
Shear strength (MPa)	200 - 300
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	300

Applications
Tool industry

Operating conditions
Copper based alloy with a nickel net interlayer to compensate the internal stresses and for gap stabilization. Suitable for brazing cemented carbides and steels. Excellent flow, capillarity and mechanical strength characteristics.

Recommended fluxes
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Heat sources
Furnace in vacuum and under protective atmosphere

Delivery forms
Tri-foil: ribbon, preforms

Notes
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