Technical Data Sheet BrazeTec 5081

Standard
ISO 17672 Ag 450
(AWS 5.8) (BAg-24)

Nominal composition [wt.-%] Ag 50; Cu 20; Zn 28; Ni 2
Permitted impurities max. [wt.-%] Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si 0.05
Max. impurities wt.-% 0.15

Technical data
Melting range acc. ISO 17672 approx. 660 - 715°C
Melting range acc. Measurement approx. 730 – 780°C (DSC –measurement)
Brazing temperature approx. 700°C
Density approx. 9.2 g/cm³
Tensile strength on K10 min. 230 MPa
Operating temp. of brazed joint approx. -200°C to +200°C (without loss in strength)

Standard delivery forms*
Wire: 1.0 - 1.5 - 2.0 mm Ø
Rods: 1.0 - 1.5 - 2.0 mm Ø, 500 mm length
Ribbon: 0.1/ 0.2/ 0.3/ 0.4 mm thickness and 70 mm width
Preforms: rings, shaped parts, sections, stamped and shaped parts, shims, discs, perforated plates

*Other delivery forms upon request

Applications
BrazeTec 5081 is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium. The reachable strength of the joint depends from the parent metals. It can be used for brazing with flame or induction brazing procedures. Typical applications are found e.g. in the tool industry.

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