

Technical Data Sheet BrazeTec 21/68

Standard

BrazeTec Standard
 ISO 3677

B-Cu87MnCo 980/1030

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

Cu 87; Mn 10; Co 3

Al 0.001; Bi 0.03; Cd 0.01; P 0.008; Pb 0.025; Si 0.05

0.15

Technical data

Melting range

approx. 990 - 1030 °C

Working temperature

approx. 1020 °C

Density

approx. 8.8 g/cm³

Shear strength acc. DIN EN 12797

200 - 300 MPa (carbide/steel)

Operating temp. of brazed joint

max. 300 °C (without loss in strength)

Standard delivery forms*

Wire:

0.8 - 1.0 - 1.5 - 2.0 - 2.5 - 3.0 mm Ø

Rods:

3.0 mm Ø, 500 mm length

Ribbon:

0.1 mm thickness and 80 mm width

Preforms:

rings, shaped parts, sections, stamped and shaped parts, shims, discs, perforated plates

*Other delivery forms upon request

Applications

BrazeTec 21/68 is a brazing alloy for cemented carbides, any steels, as well as for nickel and nickel based alloys. Due to the high brazing temperature it is only conditionally suitable for brazing in atmosphere. For brazing under protective atmosphere it is well suitable.

Typical applications are found e.g. in tool industry.

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