## Technical Data Sheet BrazeTec 21/68

### Standard
BrazeTec Standard  
ISO 3677  
B-Cu87MnCo 980/1030

### Nominal composition [wt.-%]
- Cu 87; Mn 10; Co 3

### Permitted impurities max. [wt.-%]
- Al 0.001; Bi 0.03; Cd 0.01; P 0.008; Pb 0.025; Si 0.05

### Max. impurities [wt.-%]
- 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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