Technical Data Sheet BrazeTec 21/80

Standard
BrazeTec Standard
(ISO 3677) (B-Cu86MnNi 970/990)

Nominal composition [wt.-%]
Cu 86; Mn 12; Ni 2

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 acc. Measurement approx. 970 - 1005°C (DSC –measurement)
Brazing temperature approx. 990°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: 1.5 - 2.0 - 3.0 mm Ø
Rods: 1.5 - 2.0 - 3.0 mm Ø, 500 mm length
Preforms: rings, shaped parts, sections
*Other delivery forms upon request

Applications
BrazeTec 21/80 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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