Technical Data Sheet BrazeTec CB10 Paste

Standard
BrazeTec Standard
(ISO 3677)  

Nominal composition [wt.-%]
Ag 64.8; Cu 25.2; Ti 10

Additional elements 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 of brazing alloy
approx. 780 - 805 °C

Optimum brazing temperature
approx. 850 - 950 °C

Density of brazing paste
approx. 3.9 g/cm³ (20 °C)

Metal content
approx. 85 wt.-%

Viscosity
14 - 20 Pa s (Cone-Plate; 150 µm; D= 50/s; 20 °C)

Flash point of solvent
approx. 105 °C

Evaporation temperature of binder
approx. 360 - 400 °C at 1 bar

Cleaning agent
BrazeTec Cleaning Agent P

Shelf life
min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30°C.

Packaging
Standard
0.10; 0.25 kg

Applications
BrazeTec CB10 paste is suitable for high temperature brazing of ceramics, ceramic-metal joints, graphite and diamonds. To get a joint to the ceramic a minimum brazing temperature of 850 °C has to be chosen for active brazing paste BrazeTec CB10. Higher brazing temperatures improve the wetting behavior. As brazing atmospheres pure argon (4.8 or purity 99.998%) or vacuum (app. 5 x 10⁻⁴ mbar) have to be used. In case of brazing in vacuum the brazing temperature should not be much higher than 900 °C to avoid evaporation of silver.

Active brazing alloys do not flow on ceramics. Therefore the active brazing alloy has to be applied on the surfaces to be brazed.

BrazeTec CB10 paste is suitable for screen printing. The mesh opening of screen printing fabrics should be between 150 and 220 mesh.

The strength values of joints brazed with BrazeTec CB10 paste depend on the used base materials and brazing parameters. In general it can be said that joints brazed with optimized brazing parameters fail in the ceramic.

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