Technical Data Sheet BrazeTec Cu/NiN

Standard
ISO 17672 Cu 110
(DIN EN 1044) (CU 101)
(US-Standard ANSI/AWS A5.8) (BCu-1)

Nominal composition [wt.-%] Cu min. 99.90 (brazing alloy layer)
Permitted impurities max. [wt.-%] max. 0.04 (without O and Ag)
Max. impurities [wt.-%]

Technical data
Melting range approx. 1085 °C
Working temperature approx. 1100 °C
Density approx. 8.9 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*
Ribbon: 0.35 mm thickness and 70 mm width
Preforms: stamped and shaped parts, shims, discs, perforated plates
*Other delivery forms upon request

Applications
BrazeTec Cu/NiN is a brazing alloy with a nickel net interlayer to compensate the internal stresses. The brazing alloy is suitable for brazing of cemented carbides to steel. The reachable strength of the joint depends from the parent metals. It is well suitable for brazing under protective atmosphere or under vacuum. Typical applications are found e.g. in the tool industry.

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