

## Technical Data Sheet BrazeTec 2700

### Standard

ISO 17672  
(DIN EN 1044)  
(AWS 5.8)

Ag 427  
(AG 503)  
(BAg-28)

### Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]  
Max. impurities [wt.-%]

Ag 27; Cu 38; Zn 20; Mn 9.5; Ni 5.5  
Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si 0.05  
0.3

### Technical data

Melting range acc. ISO 17672	approx. 680 - 830°C
Melting range acc. Measurement	approx. 690 – 850°C (DSC –measurement)
Brazing temperature	approx. 830°C
Density	approx. 8.7 g/cm <sup>3</sup>
Tensile strength	on K10 min. 250 MPa
Operating temp. of brazed joint	approx. -200°C to +300°C (without loss in strength)

### Standard delivery forms\*

Wire:	1.0 - 1.5 - 2.0 mm Ø
Rods:	1.0 - 1.5 - 2.0 mm Ø, 500 mm length
Ribbon:	0.1/ 0.2/ 0.3/ 0.4 mm thickness and 70 mm width
Preforms:	rings, shaped parts, sections, stamped and shaped parts, shims, discs, perforated plates

\*Other delivery forms upon request

### Applications

BrazeTec 2700 is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium. The reachable strength of the joint depends from the parent metals. It can be used for brazing with flame or induction brazing procedures. Typical applications are found e.g. in the tool industry.

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