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TD-STM-BT-E-0021-00

Technical Data Sheet BrazeTec 49/NiN

Standard

BrazeTec Standard	
ISO 3677	B-Ag49CuZnMnNi 670/690

Nominal composition [wt.-%]	(brazing alloy layer) Ag 49; Cu 27.5; Zn 20.5; Mn 2.5; Ni 0.5
Permitted impurities max. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
max. impurities [wt.-%]	0.3

Technical data

Melting range	approx. 670 - 690 °C
Working temperature	approx. 690 °C
Density	approx 9.0 g/cm³
Shear strength acc. DIN EN 12797	150 - 300 MPa (carbide/steel)
Operating temp. of brazed joint	max. 200 °C (without loss in strength)

Standard delivery forms*

Ribbon:	0.4 mm thickness and 70 mm width
Preforms:	discs, sections, shaped parts

*Other delivery forms upon request

Applications

BrazeTec 49/NiN is a low melting silver based 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 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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