

## Technical Data Sheet BrazeTec 21/68

### Standard

BrazeTec Standard  
ISO 3677

B-Cu87MnCo 980/1030

### Nominal composition [wt.-%]

Cu 87; Mn10; Co 3

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

approx. 990 - 1030 °C

Working temperature

approx. 1020 °C

Density

approx. 8.8 g/cm<sup>3</sup>

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:

0.8 - 1.0 - 1.5 - 2.0 - 2.5 - 3.0 mm Ø

Rods:

3.0 mm Ø, 500 mm length

Ribbon:

0.1 mm thickness and 80 mm width

Preforms:

rings, shaped parts, sections, stamped and shaped parts, shims, discs, perforated plates

\*Other delivery forms upon request

### Applications

BrazeTec 21/68 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.

Details in product brochures or other advertisements about our products, equipment, plant and processes are based on our research and our experience in the field of applied engineering and are merely recommendations. It is not possible to infer any warranted qualities or warranted use from these details, unless they were expressly agreed as a warranted quality. We reserve the right to make technical modifications in the course of our product development.

The user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. This shall also apply to the protection of third party property rights as well as to applications and processes. The properties of samples and specimens are binding only if these have been expressly agreed to define the quality of the goods. Information on the quality and durability and other particulars are warranted only if these are agreed and designated as such. The specifications agreed with the user/purchaser in writing are relevant for the quality of the goods and if specifications have not been agreed in writing, the information contained in our technical data sheets, specifications or drawings.

Any additional or diverging agreements on the quality must be in writing. Any suitability of the product for the presupposed or customary use which supplements or diverges from the agreed quality is out of the question. Our General Conditions of Sale and Delivery shall apply; the current version is available at <http://www.umicore-brasage.fr>.