

Technical Data Sheet BrazeTec 60/40

Standard

ISO 17672
(DIN EN 1044)

Cu 670
(CU 303)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

Cu 60; Si 0.3; Mn 0.15; Zn rem.

Al 0.01; As 0.01; Bi 0.01; Cd 0.01; Fe 0.25; Pb 0.02; Sb 0.01

0.2; Sn 0.1

Technical data

Melting range

approx. 870 - 900 °C

Working temperature

approx. 900 °C

Density

approx. 8.4 g/cm³

Shear strength acc. DIN EN 12797

approx. 150 - 300 MPa

Elongation

approx. 35 %

Electrical Conductivity

approx. 15.5 m/Ωmm²

Operating temp. of brazed joint

max. 300 °C (without loss in strength)

Standard delivery forms*

Wire:

1.5 - 2.0 - 3.0 mm Ø

Rods:

1.5 - 2.0 - 3.0 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

*Other delivery forms upon request

Applications

BrazeTec 60/40 is a brazing alloy with good flow characteristics. It can be used for brazing any steels, copper as well as for nickel and nickel based alloys. In special cases BrazeTec 60/40 can be used for brazing cemented carbides.

It can be used for brazing with flame or induction brazing procedures.

Typical applications are found e.g. in automotive and in the electric and tool industry.

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