

Technical Data Sheet BrazeTec BlueBraze 2810

Standard

BrazeTec Standard
(ISO 3677)

(*B-Cu39AgZnMnInNi-680/760*)

Nominal composition [wt.-%]

Cu 39; Ag 28; Zn 20; Mn 10; In 2; Ni 1

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

Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si 0.05 Max.
0.3

Technical data

Melting range acc. Measurement	approx. 680 - 760°C (DSC –measurement)
Brazing temperature	approx. 710°C
Density	approx 8.5 g/cm ³
Shear strength*	min. 250 MPa
Operating temp. of brazed joint	approx. +200°C (without loss in strength)

*Measured according to BrazeTec standard (AA-TM-BT-6013-D-0). Parent materials: 1.2210 & K10

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

**Other delivery forms upon request

Applications

BrazeTec BlueBraze 2810 is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of materials which are difficult to wet, like cemented carbides. The reachable strength of the joint depends on 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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