

## Technical Data Sheet BrazeTec BlueBraze 28/Cu

### Standard

BrazeTec Standard  
(ISO 3677)

(B-Cu39AgZnMnInNi-680/760)

### Nominal composition [wt.-%]

(brazing alloy layer) Cu 39; Ag 28; Zn 20; Mn 10; In 2; Ni 1

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 acc. Measurement

approx. 680 - 760°C (DSC –measurement)

Brazing temperature

approx. 710°C

Density

approx 8.7 g/cm<sup>3</sup>

Shear strength\*

min. 150 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\*

Ribbon:

0.25/ 0.3/ 0.4 mm thickness; other dimensions upon request

Preforms:

Upon request

### Applications

BrazeTec 28/Cu is a low melting silver based brazing alloy with copper interlayer to compensate the internal stresses of the joint. The brazing alloy is suitable for brazing of cemented carbides to steel. 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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