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Marketing Services

TD-STM-BT-E-1130-00

Technical Data Sheet BrazeTec D801.1

Standard	
ISO 17672	Cu 110
(AWS 5.8)	(BCu-1b)
(DIN EN 1044)	(CU101)
Nominal composition [wt.-%]	Cu min. 99.90
Permitted impurities	Cd 0.01; Pb 0.025
Max. impurities [wt.-%]	0,04 (except O and Ag)
Technical data	
Melting range of brazing alloy	approx. 1085 °C
Recommended brazing temperature	approx. 1120 °C
Density of brazing alloy	approx. 8.96 g/cm³
Density of brazing paste	approx. 3.6 g/cm³ (20 °C)
Viscosity	700 - 750 dPa s (Haake Viscotester VT 02, Sp.2, 20 ±2 °C)
Cleaning agent	Water
Shelf life	6 months in the original closed container storage temperature +5 to +30 °C. Stir well before use
Packaging*	
Standard	1; 5; 20 kg

Applications

BrazeTec D 801.1 is a flux free dosable paste with a high content of copper alloy powder.
This dosable paste can be applied by air pressure or screw dispenser techniques.
The paste has a good adhesion to the work piece and a long drying time after application.
The brazing alloy shows good flowing and wetting properties. For wide brazing gaps (>0,1mm), e.g. they occur when the parts have wide tolerances, this BrazeTec D 801.1 paste only has a limited suitability.

The copper brazing alloy can be used for brazing unalloyed and low, middle and high alloyed steels.
The brazing process has to be carried out in vacuum or protective atmosphere.
It is possible to harden brazed steel work pieces.

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