

Technical Data Sheet BrazeTec D 7200.1

Standard

ISO 17672
(DIN EN 1044) Ag 272
(AG 401)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%] Ag 72; Cu 28
Al 0.001; Bi 0.030; Cd 0.030; P 0.008; Pb 0.025; Si 0.05
Max. impurities [wt.-%] 0.15

Technical data

Melting range of brazing alloy approx. 780 °C
Recommended brazing temperature approx. 850 °C
Density of brazing alloy approx. 10.0 g/cm³
Density of brazing paste approx. 4.4 g/cm³ (20 °C)
Viscosity 600 - 700 dPa s (Haake Viscotester 02; Sp. 2; 20 ±2 °C)
Tensile strength acc. DIN EN 12797 with S235: 340 MPa; with E295: 390 MPa
Operating temperature of joint max. 200 °C (without loss of strength)
Cleaning agent Water
Shelf life min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30°C. stir well before use

Packaging

Standard 1; 5; 20 kg

Applications

BrazeTec D 7200.1 is a brazing paste with high metal content. The paste has a good adhesion and is drying slowly.

The brazing process has to be carried out in vacuum or protective atmosphere. No residues are generated during brazing.

BrazeTec D 7200.1 has a good flow and wetting characteristic. It has a good electrical conductivity (app. 48m/Ohm mm) and heat conductivity (app. 335 W/mK).

The brazing alloy is suitable for vacuum applications at room temperature or higher temperatures.

Further comments: At brazing temperatures above 1000°C in vacuum atmosphere a noticeable amount of silver evaporates. This can be avoided by brazing with partial pressure of argon (e.g. 10 mbar).

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