

Technical Data Sheet BrazeTec D 7200.2

Standard

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

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%] Ag 72; Cu28
Al 0.001; Bi 0.030; Cd 0.010; 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. 3.8 g/cm³ (20 °C)
Metal content approx. 90 wt.-%
Grain size of brazing alloy powder < 100 µm
Viscosity 300 ± 30 Pa s (Cone-Plate; 150 µm; D= 0,5/s; 20°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)
Evaporation temperature of binder approx. 180 - 420°C at 1 bar
Cleaning agent BrazeTec Cleaning Agent TD
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 kg

Applications

BrazeTec D 7200.2 is a dosable brazing paste with a high metal content. The paste can be used for brazing of any steels, copper and copper-based alloys as well as for nickel and nickel-based alloys. BrazeTec D 7200.2 is well suitable for brazing under protective atmosphere and under vacuum. The paste contains a low melting silver based brazing alloy with excellent flow and wetting characteristics, which has good electrical (approx. 48m/Wmm²) and thermal conductivity (approx. 335 W/mK). The alloy can be used for vacuum applications at room and higher operating temperatures. Typical applications are found e.g. in the electric industry. (Brazing of metallized ceramic).

Further comments: Brazing procedures under vacuum should be done at temperatures not much above 900°C to avoid evaporation of silver as far as possible.

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