

Technical Data Sheet BrazeTec BlueBraze 28/Cu plus

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/cm³

Shear strength*

> 180 MPa (carbide/steel)

Operating temp. of brazed joint

Max +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 plus is a low melting silver based brazing alloy with modified 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 from 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.

*Measured according to BrazeTec standard (AA-TM-BT-6013-D-00): Parent materials: 1.2210 & K10

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