

Technical Data Sheet BrazeTec 2700

Standard

ISO 17672
(DIN EN 1044)
(AWS 5.8)

Ag 427
(AG 503)
(BAg-28)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]
Max. impurities [wt.-%]

Ag 27; Cu 38; Zn 20; Mn 9.5; Ni 5.5
Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si 0.05
0.3

Technical data

Melting range acc. ISO 17672
Melting range acc. Measurement
Brazing temperature
Density
Tensile strength
Operating temp. of brazed joint

approx. 680 - 830°C
approx. 690 – 850°C (DSC –measurement)
approx. 830°C
approx. 8.7 g/cm³
on K10 min. 250 MPa
approx. -200°C to +300°C (without loss in strength)

Standard delivery forms*

Wire: 1.0 - 1.5 - 2.0 mm Ø
Rods: 1.0 - 1.5 - 2.0 mm Ø, 500 mm length
Ribbon: 0.1/ 0.2/ 0.3/ 0.4 mm thickness and 70 mm width
Preforms: rings, shaped parts, sections, stamped and shaped parts,
shims, discs, perforated plates

*Other delivery forms upon request

Applications

BrazeTec 2700 is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium. 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.

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