TD-STM-BT-E-0015-00

Technical Data Sheet BrazeTec 6488

Standard

BrazeTec Standard	
(ISO 3677)	*(B-Ag64CuInMnNi 730/780))*

Nominal composition [wt.-%]	Ag 64; Cu 26; Mn 2; Ni 2; In 6
Permitted impuritiesmax. [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 rangeacc. Measurement	approx. 730 – 780°C
Brazing temperature	approx. 770°C
Density	approx. 9.6 g/cm³
Shear strength acc. DIN EN 12797	approx. 150 - 300 MPa (cemented carbide/steel)
Operating temp. of brazed joint	approx. -200°C to +200°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 6488 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.

BrazeTec 6488 will be used especially if parts are going to get a vacuum coating as e.g. TiN and therefore Zn-containing brazing alloys are not suitable.

It can be used for brazing with flame, with induction heating and in a furnace under protective atmospheres.

Typical applications are found e.g. in the tool industry.

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