

Technical Data Sheet BrazeTec 7291

Standard

BrazeTec Standard
(ISO 3677)

(B-Ag72Zn 710/730)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

Ag 72; Zn 28

Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si 0.05

0.15

Technical data

Melting range acc. Measurement

approx. 710 – 730 °C (DSC –measurement)

Brazing temperature

approx. 730 °C

Density

approx 8.43 g/cm³

Shear strength acc. DIN EN 12797

with S235: min 150 MPa

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

*Other delivery forms upon request

Applications

BrazeTec 7291 is a low melting Cu- Free silver based brazing alloy.

It can be used for brazing unalloyed, low and high alloyed steels, copper and copper-based alloys as well as for nickel and nickel-based alloys.

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 refrigeration and air conditioning industry, automotive and in the electric industry.

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