

Technical Data Sheet BrazeTec D804.1

Standard

BrazeTec Standard
(ISO 3677)

(B-Cu87MnNi-980/1020)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Cu Rem.; Mn 10.0; Ni 3.0

Cd 0.010; Pb 0.025

Technical data

Melting range of brazing alloy	approx. 970 - 1030 °C
Optimum brazing temperature	approx. 1080 °C
Density of brazing alloy	approx. 8.75 g/cm ³
Density of brazing paste	approx. 3.7 g/cm ³ (20 °C)
Viscosity	550 - 650 dPa s (Haake Viscotester VT 02, Sp.2, 20 ±2 °C)
Cleaning agent	Water
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; 5; 20 kg

Applications

BrazeTec D 804.1 is a dispensable, flux free copper based brazing paste with a high metal content. The paste adheres well on the part and dries very slowly at ambient temperatures.

The brazing alloy shows good flowing and wetting properties. Shear strength values up to 300 MPa can be obtained for cemented carbides - steel joints.

The dew point of the brazing atmosphere should be below - 40 °C to avoid oxidation of the contained manganese.

Due to the vapor pressure of the manganese the alloy should be used only in exceptional cases in vacuum processes.

Due to relative weak deformation behavior of the alloy the paste should not be used for highly stressed steel joints.

The paste can be used in protective atmosphere furnaces on cemented carbides, any steels, tungsten, tantalum and their alloys.

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

Details in product brochures or other advertisements about our products, equipment, plant and processes are based on our research and our experience in the field of applied engineering and are merely recommendations. It is not possible to infer any warranted qualities or warranted use from these details, unless they were expressly agreed as a warranted quality. We reserve the right to make technical modifications in the course of our product development.

The user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. This shall also apply to the protection of third party property rights as well as to applications and processes. The properties of samples and specimens are binding only if these have been expressly agreed to define the quality of the goods. Information on the quality and durability and other particulars are warranted only if these are agreed and designated as such. The specifications agreed with the user/purchaser in writing are relevant for the quality of the goods and if specifications have not been agreed in writing, the information contained in our technical data sheets, specifications or drawings.

Any additional or diverging agreements on the quality must be in writing. Any suitability of the product for the presupposed or customary use which supplements or diverges from the agreed quality is out of the question. Our General Conditions of Sale and Delivery shall apply; the current version is available at <http://www.umicore-brasage.fr/>.