

## Technical Data Sheet BrazeTec 49/Cu plus

### Standard

BrazeTec Standard  
ISO 3677

B-Ag49CuZnMnNi 670/690

### Nominal composition [wt.-%]

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

(brazing alloy layer) Ag 49; Cu 27.5; Zn 20.5; Mn 2.5; Ni 0.5  
Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05  
0.3

### Technical data

Melting range	approx. 670 - 690 °C
Working temperature	approx. 690 °C
Density	approx 9.0 g/cm <sup>3</sup>
Shear strength acc. DIN EN 12797	200 - 300 MPa (carbide/steel)
Operating temp. of brazed joint	max. 200 °C (without loss in strength)

### Standard delivery forms\*

Ribbon: 0.2/ 0.3/ 0.4 mm thickness and 70 mm width  
Preforms: discs, sections, shaped parts

\*Other delivery forms upon request

### Applications

BrazeTec 49/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.

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