TD-STM-BT-E-0019-00

Technical Data Sheet BrazeTec 64/Cu

Standard

BrazeTec Standard	
ISO 3677	B-Ag64CuInMnNi 730/780

Nominal composition [wt.-%]	(brazing alloy layer) Ag 64; Cu 26; Mn 2; Ni 2; In 6
Permitted impurities max. [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 range	approx. 730 - 780 °C
Working temperature	approx. 770 °C
Density	approx 9.6 g/cm³
Shear strength acc. DIN EN 12797	150 - 300 MPa (carbide/steel)
Operating temp. of brazed joint	max. 200 °C (without loss in strength)

Standard delivery forms*

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

*Other delivery forms upon request

Applications

BrazeTec 64/Cu is a low melting silver based brazing alloy with 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.
BrazeTec 64/Cu 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 protect ive atmospheres.

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