TD-STM-BT-E-0712-00

Technical Data Sheet BrazeTec CB 17

Standard

BrazeTec Standard	
(ISO 3677)	*(B-Ag59CuInTi 605/720)*

Nominal composition [wt.-%]	Ag 59.1; Cu 27.2; In 12.5; Ti 1.2
Additional elements max. [wt.-%]	Al 0.001; Bi 0.030; Cd <0.010; P 0.008; Pb 0.025; Si 0.05.
Max. impurities [wt.-%]	0.15

Technical data

Melting range of brazing alloy	approx. 605 - 720°C
Brazing temperature	approx. 780 °C
Density of brazing paste	approx. 3.9 g/cm³ (20°C)
Metal content	approx. 92 wt.-%
Viscosity at the date of production	540 - 720 Pa s (Cone-Plate; 150 µm; D= 0.5/s; 20°C)
Flash point of solvent	approx. 105°C
Evaporation temperature of binder	approx. 360 - 400°C at 1 bar
Cleaning agent	BrazeTec Cleaning Agent P
Shelf life	6 months in the original closed container storage temperature +5 to +30°C. Avoid rapid changes in temperature. Stir well before use

Packaging

Standard	0.10; 0.25 kg

Applications

BrazeTec CB 17 paste is suitable for high temperature brazing of PCD, but also for diamond, ceramics and ceramic-metal compounds. As brazing atmospheres pure argon (4.8 or purity 99.998%) or vacuum (better than app. 5 x 10^{-4} mbar) must be used. In case of brazing in vacuum the brazing temperature should not be much higher than 900°C to avoid evaporation of silver.
Active brazing alloys do not flow on ceramics. Therefore, the active brazing alloy must be applied on the surfaces to be brazed.
BrazeTec CB 17 paste is suitable for screen printing and dispensing.
The strength values of joints brazed with BrazeTec CB 17 paste depend on the used base materials and brazing parameters. In general, it can be said that joints brazed with optimized brazing parameters fail e.g. in the ceramic.

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