



Technical Data Sheet BrazeTec 21/80



TD BT 0653 E.03

Inhalt

Standard

BrazeTec Standard
ISO 3677

B-Cu86MnNi 970/990

Nominal composition [wt.-%]

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

Cu 86; Mn 12; Ni 2
Al 0,001; Bi 0,03; Cd 0,01; P 0,008; Pb 0,025; Si 0,05
0,15

Technical data

Melting range	approx. 970 - 990 °C
Working temperature	approx. 990 °C
Density	approx. 8,8 g/cm ³
Shear strenght acc. DIN EN 12797	200 - 300 MPa (carbide/steel)
Operating temp. of brazed joint	max. 300 °C (without loss in strength)

Standard delivery forms*

Wire:	1,2 + 1,6 mm Ø
Rods:	3,0 mm Ø, 500 mm length
Preforms:	rings, shaped parts, sections

*Other delivery forms upon request

Applications

BrazeTec 21/80 is a brazing alloy for cemented carbides, any steels, as well as for nickel and nickel based alloys. Due to the high brazing temperature it is only conditionally suitable for brazing in atmosphere. For brazing under protective atmosphere it is well suitable. Typical applications are found e.g. in tool industry.

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