



Technical Data Sheet BrazeTec 7200



TD BT 0022 E.02

Inhalt

Standard

DIN EN 1044
ISO 3677

AG 401(L-Ag72 acc. DIN 8513)
B-Ag72Cu-780

Nominal composition [wt.-%]

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

Ag 72; Cu 28
Al 0,001; Bi 0,030; Cd 0,010; P 0,008; Pb 0,025; Si 0,05
0,15

Technical data

Melting range approx. 780 °C (DIN EN 1044)
Working temperature approx. 780 °C
Density approx. 10,0 g/cm³
Tensile strength acc. DIN EN 12797 with S235: 340 MPa; with E295: 390 MPa
Elongation approx. 17 %
Electrical Conductivity approx. 46,1
m/ Ωmm²
Operating temp. of brazed joint max. 200 °C (without loss in strength)

Standard delivery forms*

Wire: 1,0 - 1,5 - 2,0 mm Ø
Rods: 1,0 - 1,5 - 2,0 mm Ø, 500 mm length
Ribbon: 0,1/ 0,2/ 0,3/ 0,4 mm thickness and 70 mm width
Preforms: rings, shaped parts, sections, stamped and shaped parts,
shims, discs, perforated plates

*Other delivery forms upon request

Applications

BrazeTec 7200 can be used for brazing any steels, copper and copper based alloys as well as for nickel and nickel based alloys.

It is well suitable for brazing under protective atmosphere and under vacuum. The brazing temperature in the furnace is determined by the parent metals. Brazing procedures under vacuum should be done at temperatures not much above 900 °C to avoid evaporation of silver as far as possible.

Typical applications are found e.g. in the electric industry. (Brazing of metallised ceramic)

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Dokumenten-Informationen

Dokument	Helmut Ries/Wolfgang/LNWW		
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Autor(en):	Helmut Ries/Wolfgang/LNWW	Erstell-Datum:	10.07.2000 (Urversion)
	Daniel Schnee/Wolfgang/LNWW		13.10.2005 (act.Version)
Letzte ändernde Dokumentspeicherun g:	Hartmut Schmoor/Wolfgang/LNWW	Geändert-Datum:	03.11.2005
Geprüft:	Juergen Scherpf/Wolfgang/LNWW	Prüf-Datum:	01.11.2005
Freigegeben:	Hartmut Schmoor/Wolfgang/LNWW	Freigabe-Datum:	03.11.2005
Archiviert:		Archiviert-Datum:	

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