



Technical Data Sheet BrazeTec Cu/NiN



TD BT 0655 E.02

Inhalt

Standard

BrazeTec Standard
ISO 3677

B-Cu100- 1085

Nominal composition [wt.-%]

Cu min. 99,90

Permitted impurities max. [wt.-%]

Max. impurities [wt.-%]

max. 0,04 (without O and Ag)

Technical data

Melting range

approx. 1085 °C

Working temperature

approx. 1090 °C

Density

approx. 8,9 g/cm³

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*

Ribbon:

0,35 mm thickness and 70 mm width

Preforms:

stamped and shaped parts, shims, discs, perforated plates

*Other delivery forms upon request

Applications

BrazeTec Cu/NiN is a brazing alloy with a nickel net interlayer to compensate the internal stresses. The brazing alloy is suitable for brazing of cemented carbides to steel. The reachable strength of the joint depends from the parent metals.

It is well suitable for brazing under protective atmosphere or under vacuum.

Typical applications are found e.g. in the tool industry.

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Dokumenten-Informationen

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|---|-------------------------------|-------------------|--|
| Dokument | Helmut Ries/Wolfgang/LNWW | | |
| Eigentümer: | | | |
| Autor(en): | Helmut Ries/Wolfgang/LNWW | Erstell-Datum: | 10.07.2000 (Urversion) 11.10.2005 (act.Version) |
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