



## Technical Data Sheet BrazeTec 7200



TD BT 0022 E.03

### Inhalt

#### Standard

DIN EN 1044  
ISO 3677

AG 401  
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/cm<sup>3</sup>  
Tensile strength acc. DIN EN 12797 with S235: 340 MPa; with E295: 390 MPa  
Elongation approx. 17 %  
Electrical Conductivity approx. 46,1  
m/ Ωmm<sup>2</sup>  
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 unalloyed, low and high alloyed 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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