



## Technical Data Sheet BrazeTec 49/NiN



TD BT 0021 E.02

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#### Standard

BrazeTec Standard  
ISO 3677

B-Ag49CuZnMnNi 670/690

#### Nominal composition [wt.-%]

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

(brazing alloy layer) Ag 49; Cu 27,5; Zn 20,5; Mn 2,5; Ni 0,5  
Al 0,001; Bi 0,030; Cd 0,010; P 0,008; Pb 0,025; Si 0,05  
0,3

#### Technical data

Melting range	approx. 670 - 690 °C
Working temperature	approx. 690 °C
Density	approx. 9,0 g/cm <sup>3</sup>
Shear strenght acc. DIN EN 12797	150 - 300 MPa (carbide/steel)
Operating temp. of brazed joint	max. 200 °C (without loss in strength)

#### Standard delivery forms\*

Ribbon: 0,4 mm thickness and 70 mm width  
Preforms: discs, sections, shaped parts

\*Other delivery forms upon request

#### Applications

**BrazeTec 49/NiN** is a low melting silver based 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 can be used for brazing with flame or induction brazing procedures.

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

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