TECHNICAL DATASHEET

ITALBRAS

Brazing is BrazeTec

Brazing alloy BrazeTec 21/68   TD EN 21-68 REV. 4

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	87	-	-	-	-	10	-	3 Co	-	-	-

Technical data:

Melting range (°C)	990 - 1030
Working temperature (°C)	1020
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductibility (m/Ω mm²)	-
Elongation %	-
Density (g/cm^3)	8,80
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	200 - 300
Operating temperature of brazed joint (min/max) ± (°C)	300

Applications
Tool industry

Operating conditions
Copper based alloy with excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing cemented carbides, steel, nickel and nickel alloys. It is mainly used with furnace under protective atmosphere, due to the high working temperature. Free from Zn.

Recommended fluxes
H spezial, H 285, S spezial

Heat sources
Induction heating, furnace in vacuum or under protective atmosphere

Delivery forms
Wire, rings

Notes