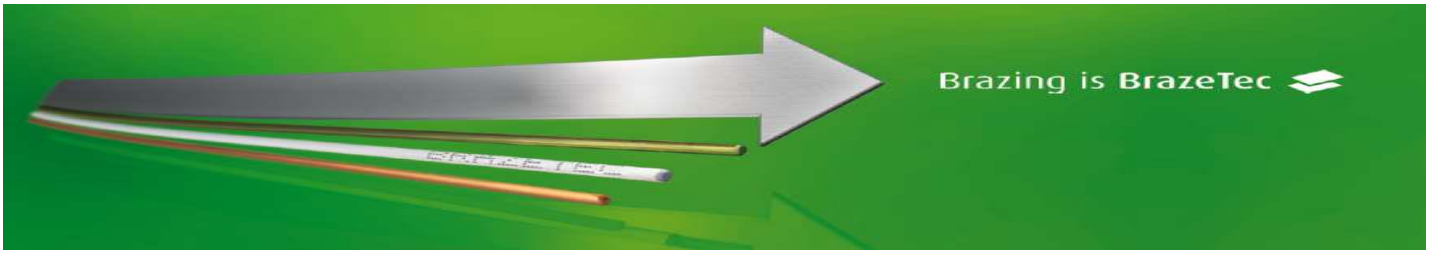
TECHNICAL DATASHEET



Brazing alloy BrazeTec 49/Cu 17

TD EN 49/Cu 17 REV. 1

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
49	27,5	20,5	-	-	-	2,5	0,5	-	-	-	-

Technical data:

Melting range (°C)	670 - 690
Working temperature (°C)	690
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductibility (m/Ω mm²)	-
Elongation %	-
Density (g/cm^3)	9
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	150 - 300
Operating temperature of brazed joint (min/max) ± (°C)	-

Applications
Tool industry

Operating conditions
Silver based brazing alloy. Partially increased copper interlayer to compensate the internal stresses of the joint. Excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing of cemented carbides and steel.

Recommended fluxes
H spezial, H 285
Heat sources
Flame, induction heating

Delivery forms
Tri-foil: ribbon, preforms

Notes
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