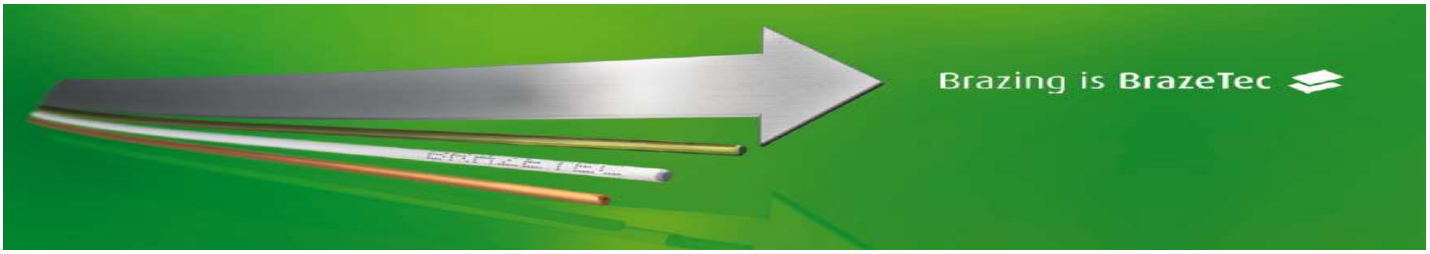
TECHNICAL DATASHEET



Brazing alloy BrazeTec 49/Cu 13

TD EN 49/Cu 13 REV. 4

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)	9,0
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 with double-copper interlayer, compared to 49/Cu alloy, to compensate the internal stresses of the joint. Excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing 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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