



Brazing alloy BrazeTec 49/Cuplus

TD EN 49-Cuplus 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 conductivity (m/Ω mm ²)	-
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)	200

Applications

Tool industry

Operating conditions

Silver based alloy with copper interlayer to compensate the internal stresses of the joint. Excellent flow, capillarity and mechanical strength characteristics. Mechanical strength improved of 20% compared to 49/Cu alloy. 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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