



Brazing alloy BrazeTec 49/NiN

TD EN 49-NiN 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 brazing alloy with copper interlayer to compensate the internal stresses of the joint and for gap stabilization. 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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