



Brazing alloy BrazeTec 64/Cu

TD EN 64-Cu REV. 4

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
64	26	-	-	-	-	2	2	6 In	-	-	-

Technical data:

Melting range (°C)	730-780
Working temperature (°C)	770
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	9,6
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 alloy with copper interlayer to compensate the internal stresses of the joint. Excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing cemented carbides and steel. Especially used for inserts for subsequent PVD coating (e.g. TiN). Free from Zn.

Recommended fluxes

H spezial, H 285

Heat sources

Flame, induction heating, furnace under protective atmosphere

Delivery forms

Tri-foil: ribbon, preforms

Notes

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