



## Brazing alloy BrazeTec 6488

TD EN 6488 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	-	-	B-Ag64CuInMnNi-730/780

### 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 <sup>2</sup> )	-
Elongation %	-
Density (g/cm <sup>3</sup> )	9,6
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 excellent flow, capillarity and mechanical strength characteristics. Suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium. Especially used for inserts for subsequent PVD coating (e.g. TiN). Therefore brazing alloys containing Zn are not suitable.

### Recommended fluxes

H spezial, H 285, H paste, H 280, H 80

### Heat sources

Induction heating, flame, furnace in vacuum and under protective atmosphere

### Delivery forms

Wire, ribbon, rings

### Notes

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