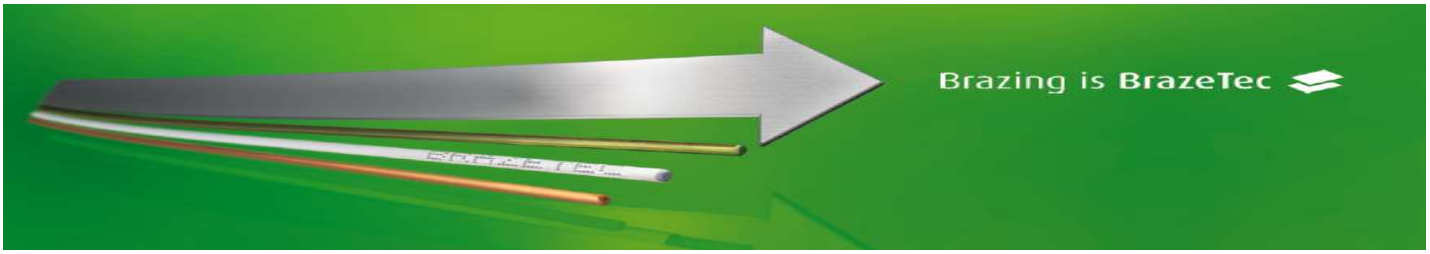
TECHNICAL DATASHEET



Brazing alloy BrazeTec 7200

TD EN 7200 REV. 5

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
72	28	-	-	-	-	-	-	-	Ag 272	AG 401	B-Ag72Cu-780

Technical data:

Melting range (°C)	780
Working temperature (°C)	780
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductibility (m/Ω mm²)	46,1
Elongation %	-
Density (g/cm^3)	10
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	200

Applications
Electrical and tool industry (diamond wires)

Operating conditions
Eutectic silver based alloy. Excellent flow, capillarity and mechanical strength characteristics. Used for brazing steel, copper and copper alloys as well as nickel and nickel alloys, metallised ceramic. Brazing procedures under vacuum should be done at temperatures not much above 900° C to avoid silver evaporation.

Recommended fluxes
N1/T, Super 1, N2/E, H paste, H sprayable, RS/A, FN/E, D 98, H spezial, H 280, H 285, H 80

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

Delivery forms
Wire, rods, powder, rings, preforms

Notes
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