Brazing alloy BrazeTec 7291

Composition (% in weight)

<table>
<thead>
<tr>
<th>Ag</th>
<th>Cu</th>
<th>Zn</th>
<th>Sn</th>
<th>Si</th>
<th>P</th>
<th>Mn</th>
<th>Ni</th>
<th>Other</th>
<th>ISO 17672:2010</th>
<th>EN 1044:1999</th>
<th>ISO 3677</th>
</tr>
</thead>
<tbody>
<tr>
<td>72</td>
<td>-</td>
<td>28</td>
<td>-</td>
<td>-</td>
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</tbody>
</table>

Technical data:

- Melting range (°C): 710-730
- Working temperature (°C): 730
- Melting range according to DSC measurement (°C):
- Min. brazing temperature (°C):
- Electrical conductivity (m/Ω mm²):
- Elongation %:
- Density (g/cm³): 8.43
- Shear strength (MPa):
- Tensile strength DIN EN 12797 (MPa):
- Operating temperature of brazed joint (min/max) ± (°C):

Applications
Electrical and tool industry, jewellery and precision metal parts, fashion accessories

Operating conditions
Silver based brazing alloy with excellent flow, capillarity and mechanical strength characteristics. Used for brazing any steels, copper and copper alloys, as well as nickel and nickel alloys. Ammonia resistant which is contained in silver cleaning products.

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

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

Delivery forms
Wire, rods, rings

Notes

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