



## Brazing alloy in paste BrazeTec CB 11

TD EN CB 11 REV. 0

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Oth er	ISO 17672:201 0	EN 1044:1999	ISO 3677
90	-	-	-	-	-	-	-	10 Ti	-	-	B-Ag90Ti 970

### Technical data:

Melting range (°C)	970
Working temperature (°C)	1000-1050
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	360-400 to 1 bar
Flash point (°C)	105
Operating temperature of brazed joint (°C)	-
Tensile strength DIN EN 12797 (MPa)	-
Alloy density (g/cm <sup>3</sup> )	-
Paste density (g/cm <sup>3</sup> )	3,3
Metal content (%) of total weight	85
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	1,4-2 (Cone-Plate; 150 µm; D=50/s; 20 °C)
Cleaning agent	Braze Tec Agent P
Flux type within the paste	-
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

### Applications

Tool industry, special applications

### Operating conditions

Silver based brazing alloy, Ti activated, used for high temperature brazing of ceramics, ceramic-metal joints, graphite and diamonds. We recommend a minimum brazing temperature of 1000° C for ceramic joints. Higher brazing temperatures improve the brazing alloy behaviour.

### Heat source

Brazing atmospheres in pure argon (4.8 or 99.998% purity) or in vacuum (app. 5 x 10<sup>-4</sup> mbar). In case of brazing in vacuum the temperature should not exceed 900 °C to avoid silver evaporation. Active brazing alloys do not flow on ceramics, therefore always have to be applied on the entire surface to be brazed.

### Standard packaging

Jar

The mesh opening of screen printing fabrics should be between 150 and 220 mesh.

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