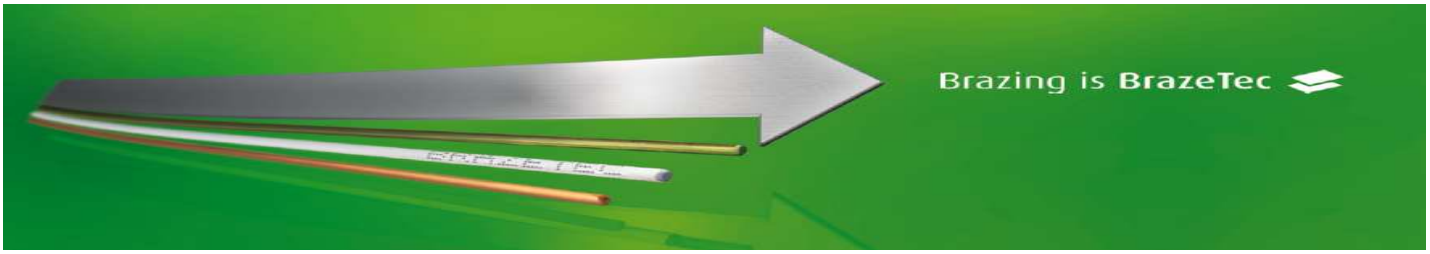
TECHNICAL DATASHEET



Brazing alloy BrazeTec CB 6

TD EN CB 6 REV. 0

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
98,4	-	-	-	-	-	-	-	1 In; 0,6 Ti	-	-	-

Technical data:

Melting range (°C)	948-959
Working temperature (°C)	1000-1050
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductibility (m/Ω mm²)	-
Elongation %	-
Density (g/cm³)	10,3
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°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. A minimum brazing temperature of 1000 °C is recommended for ceramic joints. Higher brazing temperatures improve the brazing alloy behaviour.

Recommended fluxes
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Heat sources
The brazing process has to be carried out in vacuum or with argon (4.8 or purity 99,998%) as protective atmosphere. If the brazing process is carried out in vacuum the brazing temperature should not be higher than 1000 °C to prevent silver from evaporating (if argon is used a brazing temperature of 1050 °C is possible). Active brazing alloys do not flow on ceramics, therefore always have to be applied on the entire surface to be brazed.

Delivery forms
Wire, ribbon, rings, preforms

Notes

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