



# Technical Data Sheet BrazeTec 49/Cu



## TD BT 0020 E.01

### BrazeTec Standard

B-Ag49CuZnMnNi 670/690 acc. ISO 3677

### Brazing Alloy

**Nominal composition in wt.-%** Ag 49; Cu 27,5; Zn 20,5; Mn 2,5; Ni 0,5

Permitted impurities (weight-%):

Al 0,001; Bi 0,030; Cd 0,030; P 0,008; Pb 0,025; Si 0,05; Total impurities 0,3

### Technical data

Melting range	app. 670 - 690 °C
Working temperature	app. 690 °C
Density	app. 8,9 g/cm <sup>3</sup>
Shear strength	150 - 300 MPa (cemented carbide/steel)
Operating temperature of brazed joint	max. 200 °C (without loss in strength)

### Standard delivery form\*

Ribbon: 0,4 mm thickness and 70 mm width

Preforms: stamped and shaped parts, shims, discs, perforated plates

\*Other delivery forms on request

### Application

BrazeTec 49/Cu is a low melting silver based brazing alloy with copper interlayer to compensate the internal stresses of the joint. The brazing alloy is suitable for brazing of cemented carbides to steel. The reachable strength of the joint depends from the parent metals.

It can be used for brazing with flame or induction brazing procedures.

Typical applications are found e.g. in the tool industry.

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