BRAZETEC®

# BRAZETEC Brazing Alloys for Special Applications

MEMBER OF
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## / BRAZETEC Brazing Alloys for Special Applications

BraceTec 7200 and BrazeTec 6009 brazing alloys can be brazed in air with flux as well as in a protective atmosphere furnace without flux. BrazeTec 6009 is used with flux BrazeTec special h for the brazing of stainless steel. The brazing processes in a vacuum should not exceed 900 °C for both brazing alloys to avoid the evaporation of silver. The furnace brazing temperature is governed in accordance with the base material.

| Name | Composition by Weight-% | | | | | Melting Range acc. to DSC | Melting Range acc. to ISO 17672 | Brazing Temp. min. | Density | ISO 17672 | Notes on Application | Available Forms | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **SilverBrazing Alloys** | **Ag** | **Cu** | **Sn** | **Si** | **Zn** | **in °C** | **in °C** | **in °C** | **in g/cm³** | | | | | | |
| BrazeTec 7200 | 72 | 28 | – | – | – | 780 | 780 | 780 | 10.0 | Ag 272 | metallized ceramic | • | • | • | • |
| BrazeTec 7291 | 72 | – | – | – | 28 | 710 – 730 | – | 730 | 8.43 | – | any steel; suitable for aggressive media | • | • | • | • |
| BrazeTec 6009 | 60 | 30 | 10 | – | – | 600 – 720 | 600 – 730 | 720 | 9.8 | Ag 160 | stainless steel | • | • | • | • |
| BrazeTec 8500 | 85 | 15 | – | – | – | – | 960 – 970 | 960 | 9.4 | Ag 485 | any steel; suitable for aggressive media | • | • | • | • |

| Brass Brazing Alloys | Cu | Zn | Ni | Si | Mn | in °C | in °C | in °C | in g/cm³ | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| BrazeTec 60/40 | 60 | 39.55 | – | 0.3 | 0.15 | 870 – 900 | 870 – 900 | 900 | 8.4 | Cu 670 | galvanized steel pipes | • | • | • | • |
| BrazeTec 48/10 | 48 | 41.8 | 10 | 0.2 | – | 890 – 920 | 890 – 920 | 920 | 8.4 | Cu 773 | steel pipe frames | • | • | – | • |

Wire Rods Strip Preforms

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