

# BRAZETEC Active Brazing Alloys and Active Brazing Paste



## / BRAZETEC Active Brazing Alloys

A minimal brazing temperature of 850 °C is necessary in order to achieve a bond with ceramics using BRAZETEC Active Brazing Alloys. Higher brazing temperatures can improve the wetting behaviour. Pure Argon (4.8) or vacuum (<math>10^{-3}</math>mbar) is used as the protective

brazing atmosphere. The temperature for a vacuum brazing should with CB4 should not be higher than 900 °C and for CB 2 and 6 not higher than 1,000 °C to avoid the evaporation of silver.

Name	Composition by Weight-%				Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp. min.	Density	Notes on Application	Available Forms
	Ag	Cu	In	Ti	in °C	in °C	in °C	in g/cm <sup>3</sup>		
BrazeTec CB 2	96	-	-	4	970	-	1,000	10.3	ceramic, ceramic/metal-connections, graphite, diamond, sapphire, ruby	• • • •
BrazeTec CB 4	70.5	26.5	-	3	780 – 820	-	850	9.9	silicon nitride	• • • •
BrazeTec CB 6	98.4	-	1	0.6	950 – 960	-	1,000	10.3		• • • •

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BRAZETEC active brazing pastes have a high metal content, which is optimised for the application of the product.

Materials with different Ti-contents are also available on request.

Name	Composition by Weight-%				Melting Range acc. to DSC	Brazing Temp. min.	Notes on Application	Available Forms
	Ag	Cu	In	Ti	in °C	in °C		
BrazeTec CB 10	64.8	25.2	-	10	780 – 805	850	ceramic, ceramic/metal-connections, graphite, sapphire, ruby	• •
BrazeTec CB 11	90	-	-	10	970	1,000		• •
BrazeTec CB 12	55.1	39.9	-	5	780 – 855	>900	ceramic, ceramic/metal connections, PCD, CBN applications	• •
BrazeTec CB 17	59.1	27.2	12.5	1.2	605 – 720	780 – 800		• •

