

BRAZETEC Brazing Alloys for Special Applications



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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	Mn	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	8.4	–	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