

**Standard**

BrazeTec Standard  
ISO 3677

B-Ag49CuZnMnNi 670/690

**Nominal composition [wt.-%]**

Permitted impurities max. [wt.-%]  
Max. impurities [wt.-%]

(brazing alloy layer) Ag 49; Cu 27.5; Zn 20.5; Mn 2.5; Ni 0.5  
Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05  
0.3

**Technical data**

Melting range	approx. 670 - 690 °C
Working temperature	approx. 690 °C
Density	approx. 9.0 g/cm <sup>3</sup>
Shear strength acc. DIN EN 12797	150 - 300 MPa (carbide/steel)
Operating temp. of brazed joint	max. 200 °C (without loss in strength)

**Standard delivery forms\***

Ribbon: 0.2/ 0.3/ 0.4 mm thickness and 70 mm width  
Preforms: discs, sections, shaped parts

\*Other delivery forms upon request

**Applications**

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.

Details in product brochures or other advertisements about our products, equipment, plant and processes are based on our research and our experience in the field of applied engineering and are merely recommendations. It is not possible to infer any warranted qualities or warranted use from these details, unless they were expressly agreed as a warranted quality. We reserve the right to make technical modifications in the course of our product development.

The user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. This shall also apply to the protection of third party property rights as well as to applications and processes. The properties of samples and specimens are binding only if these have been expressly agreed to define the quality of the goods. Information on the quality and durability and other particulars are warranted only if these are agreed and designated as such. The specifications agreed with the user/purchaser in writing are relevant for the quality of the goods and if specifications have not been agreed in writing, the information contained in our technical data sheets, specifications or drawings.

Any additional or diverging agreements on the quality must be in writing. Any suitability of the product for the presupposed or customary use which supplements or diverges from the agreed quality is out of the question. Our General Conditions of Sale and Delivery shall apply; the current version is available at <http://www.umicore.de/service/agbs/agbs.htm>.