









BRAZETEC BRAZING ALLOYS
FOR SPECIAL APPLICATIONS

/ BrazeTec Brazing Alloys for Special Applications

BrazeTec 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				
	Ag	Cu	Sn	Si	Zn	in °C	in °C	in °C	in g/cm ³							
Silver Brazing Alloys																
BrazeTec 7200	72	28	-	-	-	780	780	780	10.0	Ag 272	metallized ceramic	•	•	•	•	
BrazeTec 7291	72	-	-	-	28	710 - 730	-	730	8.43	-	any steel	•	•	•	•	
BrazeTec 6009	60	30	10	-	-	600 - 720	600 - 730	720	9.8	Ag 160	stainless steel	•	•	•	•	
Brass Brazing Alloys																
	Cu	Zn	Ni	Si	Mn	in °C	in °C	in °C	in g/cm ³							
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