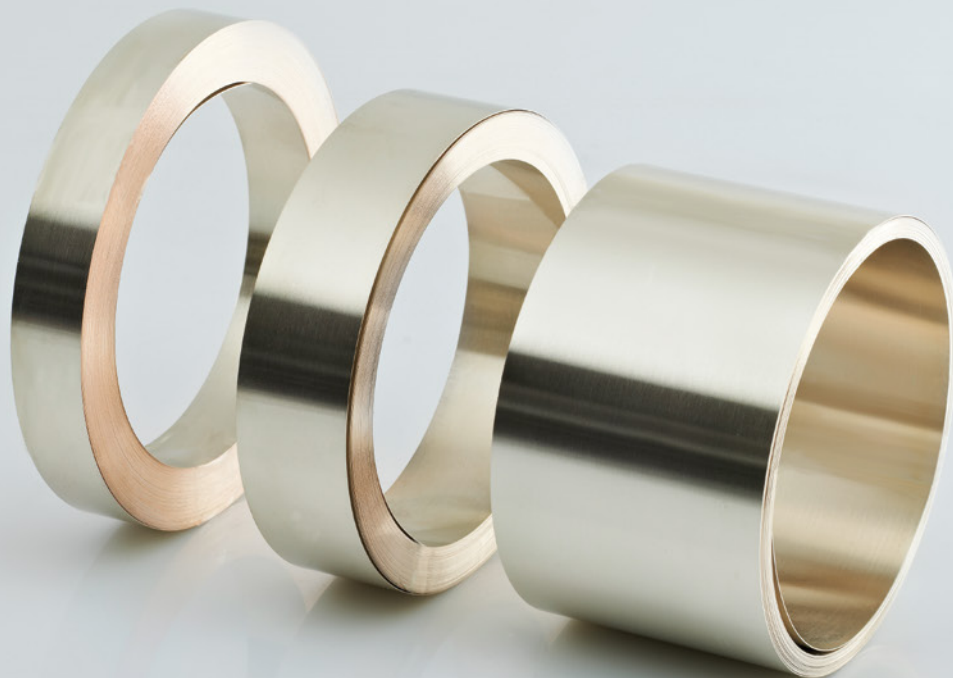






# BRAZETEC ACTIVE BRAZING ALLOYS AND ACTIVE BRAZING PASTE



## / 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 (<10<sup>-3</sup>mbar) is used as the protective brazing atmosphere. The temperature for a vacuum brazing should range between 900 °C to 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		• • • •
BrazeTec CB 6	98.4	-	1	0.6	950 – 960	-	1,000	10.3	silicon nitride	• • • •

## / BrazeTec Active Brazing Paste

BrazeTec active brazing pastes contain a metal content of approximately 85% and are suitable for dispenser application and screen

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

Name	Composition by Weight-%			Melting Range acc. to DSC	Melting Range acc. to ISO 17672	Brazing Temp. min.	Notes on Application	Available Forms
	Ag	Cu	Ti	in °C	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		•

 Wire
  Rods
  Strip
  Preforms
  Flux
  Brazing Paste