

Technical Data Sheet BrazeTec BlueBraze 2810

Standard

BrazeTec Standard
ISO 3677

B-Cu39AgZnMnInNi-680/760

Nominal composition [wt.-%]

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

Cu 39; Ag 28; Zn 20; Mn 10; In 2; Ni 1
Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
0.3

Technical data

Melting range acc. Measurement
Brazing temperature
Density
Shear strength*
Operating temp. of brazed joint

approx. 680 - 760 °C (DSC-measurement)
min. 710 °C
approx. 8.5 g/cm³
> 250 MPa (carbide/steel)
approx. -200 °C to +200 °C (without loss in strength)

Standard delivery forms**

Wire: 1.0 - 1.5 - 2.0 mm Ø
Rods: 1.0 - 1.5 - 2.0 mm Ø, 500 mm length
Ribbon: 0.1/ 0.2/ 0.3/ 0.4 mm thickness
Preforms: rings, shaped parts, sections, stamped and shaped parts, shims, discs, perforated plates

**Other delivery forms upon request

Applications

BrazeTec BlueBraze 2810 is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of materials which are difficult to wet, like cemented carbides. 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.

*Measured according to BrazeTec standard (AA-TM-BT-6013-D-00): Parent materials: 1.2210 & K10

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