TD-STM-BT-E-1151-01

Technical Data Sheet BrazeTec D 7200.2

Standard	
ISO 17672	Ag 272
(DIN EN1044)	*(AG 401)*
Nominal composition [wt.-%]	Ag 72; Cu28
Permitted impuritiesmax. [wt.-%]	Al 0.001; Bi 0.030; Cd 0.010; P 0.008; Pb 0.025; Si 0.05
Max. impurities [wt.-%]	0.15
Technical data	
Melting range of brazing alloy	approx. 780 °C
Recommended brazing temperature	approx. 850 °C
Density of brazing alloy	approx. 10.0 g/cm³
Density of brazing paste	approx. 3.8 g/cm³ (20 °C)
Metal content	approx. 90 wt.-%
Grain size of brazing alloy powder	< 100 µm
Viscosity	300 ± 30 Pa s (Cone-Plate; 150 µm; D= 0,5/s; 20°C)
Tensile strength acc. DIN EN 12797	with S235: 340 MPa; with E295: 390 MPa
Operating temperature of joint	max. 200°C (without loss of strength)
Evaporation temperature of binder	approx. 180 - 420°C at 1 bar
Cleaning agent	BrazeTec Cleaning Agent TD
Shelf life	min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30°C. stir well before use
Packaging	
Standard	1 kg

Applications

BrazeTec D 7200.2 is a dosable brazing paste with a high metal content. The paste can be used for brazing of any steels, copper and copper-based alloys as well as for nickel and nickel-based alloys. BrazeTec D 7200.2 is well suitable for brazing under protective atmosphere and under vacuum.
The paste contains a low melting silver based brazing alloy with excellent flow and wetting characteristics, which has good electrical (approx. 48m/Wmm²) and thermal conductivity (approx. 335 W/mK). The alloy can be used for vacuum applications at room and higher operating temperatures. Typical applications are found e.g. in the electric industry. (Brazing of metallized ceramic).

Further comments: Brazing procedures under vacuum should be done at temperatures not much above 900°C to avoid evaporation of silver as far as possible.

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