Technical Data Sheet BrazeTec 7200

Standard	
ISO 17672	Ag 272
(DIN EN 1044)	*(AG 401)*
(AWS 5.8)	*(BAg-8)*
Nominal composition [wt.-%]	Ag 72; Cu 28
Permitted impurities max. [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	approx. 780 °C (DIN EN 1044)
Working temperature	approx. 780 °C
Density	approx. 10.0 g/cm³
Tensile strength acc. DIN EN 12797	with S235: 340 MPa; with E295: 390 MPa
Elongation	approx. 17 %
Electrical Conductivity	approx. 46.1 m/ Ωmm²
Operating temp. of brazed joint	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 and 70 mm width
Preforms:	rings, shaped parts, sections, stamped and shaped parts, shims, discs, perforated plates

*Other delivery forms upon request

Applications

BrazeTec 7200 can be used for brazing unalloyed, low and high alloyed steels, copper and copper based alloys as well as for nickel and nickel based alloys.
It is well suitable for brazing under protective atmosphere and under vacuum. The brazing temperature in the furnace is determined by the parent metals. Brazing procedures under vacuum should be done at temperatures not much above 900 °C to avoid evaporation of silver as far as possible.
Typical applications are found e.g. in the electric industry. (Brazing of metallized ceramic)