

Technical Data Sheet BrazeTec D 7200.1

Standard

ISO 17672
(DIN EN 1044)

Ag 272
(AG 401)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%] Ag 72; Cu 28
Al 0.001; Bi 0.030; Cd 0.030; 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. 4.4 g/cm³ (20 °C)
Viscosity 600 - 700 dPa s (Haake Viscotester 02; Sp. 2; 20 ±2 °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)
Cleaning agent Water
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; 5; 20 kg

Applications

BrazeTec D 7200.1 is a brazing paste with high metal content. The paste has a good adhesion and is drying slowly.

The brazing process has to be carried out in vacuum or protective atmosphere. No residues are generated during brazing.

BrazeTec D 7200.1 has a good flow and wetting characteristic. It has a good electrical conductivity (app. 48m/Ohm mm) and heat conductivity (app. 335 W/mK).

The brazing alloy is suitable for vacuum applications at room temperature or higher temperatures.

Further comments: At brazing temperatures above 1000°C in vacuum atmosphere a noticeable amount of silver evaporates. This can be avoided by brazing with partial pressure of argon (e.g. 10 mbar).

Details in product brochures or other advertisements about our products, equipment, plant and processes are based on our research and our experience in the field of applied engineering and are merely recommendations. It is not possible to infer any warranted qualities or warranted use from these details, unless they were expressly agreed as a warranted quality. We reserve the right to make technical modifications in the course of our product development.

The user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. This shall also apply to the protection of third party property rights as well as to applications and processes. The properties of samples and specimens are binding only if these have been expressly agreed to define the quality of the goods. Information on the quality and durability and other particulars are warranted only if these are agreed and designated as such. The specifications agreed with the user/purchaser in writing are relevant for the quality of the goods and if specifications have not been agreed in writing, the information contained in our technical data sheets, specifications or drawings.

Any additional or diverging agreements on the quality must be in writing. Any suitability of the product for the presupposed or customary use which supplements or diverges from the agreed quality is out of the question. Our General Conditions of Sale and Delivery shall apply; the current version is available at <http://www.saxonia-tm.de/en/TechnicalMaterials/aqbs/>.