



Technical Data Sheet

BrazeTec 5009

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TD BT 0208 E.02

Cadmium - containing brazing alloy.

Please note the recommendations

in our

Material Safety Data Sheet.

Standard

DIN EN 1044 AG 351(L-Ag50CdNi acc. DIN 8513)

B-Ag50CdZnCuNi 635/655 acc. ISO 3677

Nominal composition in wt.-%

Ag 50; Cu 15,5; Zn 15,5; Cd 16; Ni 3

Permitted impurities (weight-%):

Al 0,001; Bi 0,030; Cd 0,030; P 0,008; Pb 0,025; Si 0,05; Total impurities 0,15

Technical data

Melting range	app. 635-655°C	(DIN EN 1044)
Working temperature	app. 660°C	(DIN EN 1044)
Density	app. 9,5 g/cm ³	(DIN EN 1044)
Shear strength acc. DIN EN 12797	150 - 300 Mpa	(carbide/steel)
Operating temperature of brazed joint	max. 150°C	(without loss in strength)

Standard delivery form*

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 parts, lamina, discs, perforated plates

*Other delivery forms on request

Application

BrazeTec 5009 is a low melting silver based brazing alloy with excellent flow characteristics. The brazing alloy is suitable for brazing of cemented carbides and materials which are difficult to wet, such as tungsten, molybdenum, tantalum and chromium. 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 electric and automotive industry.