Product Information

Nickel-Silver Brazing Alloy Cu 773

Acc. EN ISO 17672, CU 305 – EN 1044, B-Cu48ZnNi(Si)-890/920 – EN ISO 3677
For brazing steel, copper, nickel and casting material

Nickel-Silver Brazing Alloy “blank“, bare without flux,
Nickel-Silver Brazing Alloy “UM“(flux coated), flux type FH 21- EN ISO 18496 (former EN 1045)

Art.-No.: 3020..../3021....

Description

Nickel-silver rods with high strength for brazing steel, copper, nickel and casting materials as well as welding rods for welding brass and bronze.

Properties

FELDER Nickel-Silver Brazing Alloy has excellent flow characteristics. Due to the Mn-, Si- and Sn- contents the solder shows an optimal resistance against corrosion and prevents cracking.

Composition (weight-%) (Cu 773 – EN ISO 17672)	:	Cu	46.0 - 50.0
		Ni	8.0 - 11.0
		Si	0.1 - 0.3
		Zn	rest
Working temperature	:	≥ 900 °C	
Melting range	:	890 °C - 920 °C	
Density	:	8,7 g/cm³	
Tensile strength of soldering	:	at chrome nickel steel up to 800 N/mm² at structural steel 400 - 450 N/mm²	
Hardness HB	:	150 -180	

Application field

For brazing steel, casting materials, copper and nickel. The brazed joints are applicable with operating temperatures up to 450 °C. In addition, our nickel-silver rods are suitable for welding brass and bronze. It is also useable to manufacture wear resistant coatings.

Application advice

Brazing parts must be free of oxide layers, tinder, dross, oils and greases.
When using bare rods, we recommend our **FELDER Brazing Flux Paste (or Powder) "UNIVERSAL"**.

 Stand: 12/24

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When using flux-coated rods:
Pre-heat the work piece up to approx. 400 °C, apply brazing rod and let the flux melt off, then heat up to working temperature and let the solder melt off. The flame of the burner should be adjusted neutral. The flux residues must be removed thoroughly with water.
Because of the risk of chromium-carbide precipitation, attention must be paid to short soldering times in the temperature range 600 -1000 °C.

Delivery forms

Delivery forms	Dimensions
1000 mm rods bare	Ø 2,0 mm
	Ø 3,0 mm
	Other diameter on request
500 mm rods flux-coated	Ø 2,0 mm
	Ø 2,5 mm
	Ø 3,0 mm
	Ø 4,0 mm

Further information

Protect against humidity.

Please do not hesitate to contact us for any further information.

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