

TECHNICAL SHEET

Cu87MnCo3

Product name

Cu87MnCo3

Class of product

Copper based high-temperature brazing alloy

Corresponding standards

ISO 17672 -----
EN 1044 -----
AWS A5.8-04 -----
DIN 8513 -----

Nominal composition (weight %)

Cu: 87
Mn: 10
Co: 3

Physical and technical properties

Melting range (Solidus – Liquidus): 980 – 1.030 °C
Brazing temperature: ~ 1.050 °C
Density: 8,7 g/cm³
Continuous service joint operating temp.: max 300 °C

Range of application

Cu87MnCo3 is a copper based, high temperature brazing alloy.

It is suitable to join steels, stainless steels, nickel and nickel alloys and cemented carbides.

The alloy offers protection against interfacial corrosion when used on stainless steel.

Being zinc-free, and because of its high brazing temperature, Cu87MnCo3 is usually used only in protective atmosphere furnace brazing; furnace atmosphere should have a dew point lower than - 40 °C to ensure good results.

Occasionally the alloy can be used also in open air brazing (by flame or by induction), with the use of a proper high temperature flux.

Typical application of Cu87MnCo3 are in the field of carbide and diamond tools.

Characteristics Make-up

Rods
Wires
Strips
Rings
Preforms from Wire and from Strip
Pastes & Powders

NOTE:

Information contained in this data sheet are based on the knowledge available to us at the date of last document revision and are believed to be accurate. Anyway, no data contained in this data sheet may be regarded as an assurance of any property of the product. We do not assume any responsibility for results obtained or damages occurred from the use of the information contained in this data sheet. We do not assume any responsibility for any un-proper use of the product. Users should verify the suitability and completeness of information with regard to specific use the product. As end use of product is not under our direct control, it is the user's responsibility to fully comply with applicable laws and regulations in safety and hygiene.

STELLA s.r.l.

Via Marconi 26 – 21041 ALBIZZATE (VA) – ITALY

Tel. +39-0331-985787 – Fax +39-0331-985803

info@stella-welding.com - www.stella-welding.com