

Lucas-Milhaupt BRAZE 250 Silver Based Cadmium Free Filler Metal

Category : Metal , Nonferrous Metal , Copper Alloy , Precious Metal , Silver Alloy , Solder/Braze Alloy

Material Notes:

Characteristics: Braze 250 is an intermediate temperature silver brazing alloy with a long (325EF/180EC) melting range. It has a tendency to liquefy (i.e. separate into low and high melting constituents) if heated slowly through its melting range. Therefore, it is preferable to use this alloy where the assembly can be heated rapidly to brazing temperature. The long melting range of this alloy is useful when wide gap joints are brazed since it assists in producing larger fillets than more fluid alloys. Where the higher brazing temperature and characteristics of this alloy are permissible, the lower silver content affords a saving. **Applications:** Braze 250 is a useful intermediate temperature brazing alloy for joining a variety of ferrous and non-ferrous alloys capable of being heated to 1600EF/870EC without damage. It has found special use as a bearing surface material on rubbing seals in jet engine compressors. Information provided by Lucas-Milhaupt, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Lucas-Milhaupt-BRAZE-250-Silver-Based-Cadmium-Free-Filler-Metal.php

Physical Properties	Metric	English	Comments
Density	8.95 g/cc	0.323 lb/in ³	

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	172 - 207 MPa	25000 - 30000 psi	Copper butt joint
	241 - 276 MPa	35000 - 40000 psi	Nickel-Silver butt joint
	241 - 310 MPa	35000 - 45000 psi	Brass butt joint
Elongation at Break	8.0 - 9.0 %	8.0 - 9.0 %	% in 2", Copper butt joint
	9.0 - 18 %	9.0 - 18 %	% in 2", Brass butt joint

Thermal Properties	Metric	English	Comments
Melting Point	677 - 857.2 Â°C	1250 - 1575 Â°F	
Solidus	677 Â°C	1250 Â°F	Melting Point
Liquidus	857.2 Â°C	1575 Â°F	Flow Point

Component Elements Properties	Metric	English	Comments
Copper, Cu	51.5 - 53.5 %	51.5 - 53.5 %	
Other, total	<= 0.15 %	<= 0.15 %	
Silver, Ag	24 - 26 %	24 - 26 %	
Zinc, Zn	21.5 - 23.5 %	21.5 - 23.5 %	

Electrical Properties	Metric	English	Comments
Electrical Resistivity	0.00000706 ohm-cm	0.00000706 ohm-cm	

Descriptive Properties	Value	Comments
Color	Brass Yellow	

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