

Lucas-Milhaupt BRAZE 380

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

Material Notes:

Characteristics: Braze 380 is a free-flowing, low temperature filler metal with excellent wetting of most ferrous and non-ferrous base metals, and is a good substitute for cadmium-bearing filler metals with similar silver contents. The material is best suited for narrow gap situations (.001"-.005" clearance). Handy Flux, Handy Flux Type B-1 or dispensable Handy Flux Types D or DB should be used with this filler metal. **Applications:** Braze 380 is a good general purpose low temperature brazing filler metal for use in cadmium-free brazing applications, such as air conditioning and refrigeration which involve the joining of steels, copper, copper alloys and nickel alloys. **Specifications:** Braze 380 is made to conform to the following specifications- AWS 5.8 BAg-34, Boiler & Pressure Vessel Code Sec II-C BAg-34, SAE AMS-4761

Information provided by Lucas-Milhaupt, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Lucas-Milhaupt-BRAZE-380.php

Physical Properties	Metric	English	Comments
Density	9.06 g/cc	0.327 lb/in ³	

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	214 - 228 MPa	31000 - 33000 psi	Copper butt joint
	241 - 310 MPa	35000 - 45000 psi	Brass butt joint
	379 - 448 MPa	55000 - 65000 psi	Low Carbon Steel butt joint
	552 - 586 MPa	80000 - 85000 psi	304 Stainless Steel butt joint
Elongation at Break	2.0 - 5.0 %	2.0 - 5.0 %	% in 2", 304 Stainless Steel butt joint
	8.0 - 13 %	8.0 - 13 %	% in 2", Low Carbon Steel butt joint
	15 - 30 %	15 - 30 %	% in 2", Brass butt joint
	25 - 35 %	25 - 35 %	% in 2", Copper butt joint

Thermal Properties	Metric	English	Comments
Melting Point	649 - 721 Â°C	1200 - 1330 Â°F	
Solidus	649 Â°C	1200 Â°F	Melting Point
Liquidus	721 Â°C	1330 Â°F	Flow Point

Component Elements Properties	Metric	English	Comments
Copper, Cu	31 - 33 %	31 - 33 %	

Other total Component Elements Properties	≤ 0.15 % Metric	≤ 0.15 % English	Comments
Silver, Ag	37 - 39 %	37 - 39 %	
Tin, Sn	1.5 - 2.5 %	1.5 - 2.5 %	
Zinc, Zn	26 - 30 %	26 - 30 %	

Electrical Properties	Metric	English	Comments
Electrical Resistivity	0.00000950 ohm-cm	0.00000950 ohm-cm	

Processing Properties	Metric	English	Comments
Processing Temperature	721 - 816 Â°C	1330 - 1500 Â°F	Brazing Range

Descriptive Properties	Value	Comments
Color	Pale Yellow	

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