

## Lucas-Milhaupt BRAZE 402 Silver Based Cadmium Free Filler Metal

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

### Material Notes:

Characteristics: Braze 402 is a free-flowing, intermediate temperature filler metal and as such 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, or Handy Flux Type D or Handy Flux Type B-1 should be used with this filler metal. Information provided by Lucas-Milhaupt, Inc.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_Lucas-Milhaupt-BRAZE-402-Silver-Based-Cadmium-Free-Filler-Metal.php](http://www.lookpolymers.com/polymer_Lucas-Milhaupt-BRAZE-402-Silver-Based-Cadmium-Free-Filler-Metal.php)

Physical Properties	Metric	English	Comments
Density	9.03 g/cc	0.326 lb/in <sup>3</sup>	

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	193 - 228 MPa	28000 - 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 - 710 °C	1200 - 1310 °F	
Solidus	649 °C	1200 °F	Melting Point
Liquidus	710 °C	1310 °F	Flow Point

Component Elements Properties	Metric	English	Comments
Copper, Cu	29 - 31 %	29 - 31 %	
Other, total	<= 0.15 %	<= 0.15 %	
Silver, Ag	39 - 41 %	39 - 41 %	
Tin, Sn	1.5 - 2.5 %	1.5 - 2.5 %	

<b>Zinc Zn</b> Component Elements Properties	<b>28 - 32 %</b> Metric	<b>28 - 32 %</b> English	Comments
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Electrical Properties	Metric	English	Comments
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Electrical Resistivity	0.00000960 ohm-cm	0.00000960 ohm-cm	
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Processing Properties	Metric	English	Comments
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Processing Temperature	716 - 843 °C	1320 - 1550 °F	Brazing Range
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Descriptive Properties	Value	Comments
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Color	Pale Yellow	
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## Contact Songhan Plastic Technology Co.,Ltd.

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