

Lucas-Milhaupt BRAZE 495 Carbide Brazing Alloy

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

Material Notes:

Applications: Because of its excellent wetting properties, Braze 495 is used extensively for brazing tungsten carbide inserts to cutting tools and rock drills. It may be used for joining all types of stainless steels and carbon steels. **Characteristics:** Braze 495 is a cadmium-free, low temperature brazing filler metal for brazing tungsten carbides, steels and stainless steels. Because of its high manganese content, Braze 495 may tend to liquate (i.e. separate into low and high melting constituents). However, this can be mitigated by rapidly heating the joint assembly through the melting point of the Braze 495. In furnace brazing, it is most successfully used where the brazing alloy can be preplaced internally in the joint area in the form of rings or shims. **Specifications:** Braze 495 conforms to the following specifications- AWS A5.8 BA9-22, ASME Boiler & Pressure Vessel Code Sec. II C, SFA-5.8 BA9-22 Information provided by Lucas-Milhaupt, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Lucas-Milhaupt-BRAZE-495-Carbide-Brazing-Alloy.php

Physical Properties	Metric	English	Comments
Density	8.88 g/cc	0.321 lb/in ³	

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	338 MPa	49000 psi	1020 Carbon Steel butt joint.
	528 MPa	76600 psi	304 Stainless Steel butt joint.
	637 MPa	92400 psi	1095 Carbon Steel butt joint
Elongation at Break	4.0 %	4.0 %	% in 2", 1020 Carbon Steel butt joint.
	7.0 %	7.0 %	% in 2", 1095 Carbon Steel butt joint
	15 %	15 %	% in 2", 304 Stainless Steel butt joint

Thermal Properties	Metric	English	Comments
Melting Point	682 - 699 Â°C	1260 - 1290 Â°F	
Solidus	682 Â°C	1260 Â°F	Melting Point
Liquidus	699 Â°C	1290 Â°F	Flow Point

Component Elements Properties	Metric	English	Comments
Copper, Cu	15 - 17 %	15 - 17 %	
Manganese, Mn	7.0 - 8.0 %	7.0 - 8.0 %	
Nickel, Ni	4.0 - 5.0 %	4.0 - 5.0 %	

Other total Component Elements Properties	$\leq 0.15\%$ Metric	$\leq 0.15\%$ English	Comments
Silver, Ag	48 - 50 %	48 - 50 %	
Zinc, Zn	21 - 25 %	21 - 25 %	

Electrical Properties	Metric	English	Comments
Electrical Resistivity	0.00003027 ohm-cm	0.00003027 ohm-cm	

Processing Properties	Metric	English	Comments
Processing Temperature	699 - 816 Â°C	1290 - 1500 Â°F	Brazing Range

Descriptive Properties	Value	Comments
Color	Yellow White	

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