

Lucas-Milhaupt BRAZE 600 Silver Based Cadmium Free Filler Metal

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

Material Notes:

Characteristics: Braze 600 is a copper rich eutectiferous alloy, the eutectiferous portion of which is molten at 1300EF (705EC), about 25EF before the entire composition is completely fluid. Thus to the eye, the alloy would appear to flow at 1300EF. With this type of alloy, fluidity when brazing copper based metal is decreased, but in the brazing of silver based alloys it is increased. This effect is due to the solution of the base metal. Both nickel and iron based alloys are readily wet by Braze 600 as it contains 15% zinc. Applications: Braze 600 is generally used in place of Bag-9 (Braze 650) on silverware where only one joint is required. It is also used as a second joining filler metal in step brazing on an article. It has the same flow point as BAG-9, but the color is slightly more yellow. In a properly made joint, however, the seam should be so narrow that this difference is not noticeable after polishing. Information provided by Lucas-Milhaupt, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Lucas-Milhaupt-BRAZE-600-Silver-Based-Cadmium-Free-Filler-Metal.php

Physical Properties	Metric	English	Comments
Density	9.51 g/cc	0.344 lb/in ³	

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	172 - 207 MPa	25000 - 30000 psi	Copper butt joint
	241 - 310 MPa	35000 - 45000 psi	Brass butt joint
	379 - 414 MPa	55000 - 60000 psi	Nickel-Silver butt joint
Elongation at Break	13 - 19 %	13 - 19 %	% in 2", Brass butt joint
	20 - 25 %	20 - 25 %	% in 2", Nickel-Silver butt joint
	21 - 27 %	21 - 27 %	% in 2", Copper butt joint

Thermal Properties	Metric	English	Comments
Melting Point	673.9 - 718.3 Â°C	1245 - 1325 Â°F	
Solidus	673.9 Â°C	1245 Â°F	Melting Point
Liquidus	718.3 Â°C	1325 Â°F	Flow Point

Component Elements Properties	Metric	English	Comments
Copper, Cu	24 - 26 %	24 - 26 %	
Other, total	<= 0.15 %	<= 0.15 %	
Silver, Ag	59 - 61 %	59 - 61 %	

Zinc, Zn Component Elements Properties	14 - 16 % Metric	14 - 16 % English	Comments
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Electrical Properties	Metric	English	Comments
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Electrical Resistivity	0.00000840 ohm-cm	0.00000840 ohm-cm	
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Descriptive Properties	Value	Comments
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Color	White	
Corrosion Resistance	123 Mgs/dcm ² /Day	Concentrated Hydrofluoric Acid, Room Temperature, Constant Immersion
	35.7 Mgs/dcm ² /Day	10% Acetic Acid, 205Å°F, In Vapors
	891 Mgs/dcm ² /Day	Carbon Tetrachloride, Room Temperature, Presence of Water
	9.3 Mgs/dcm ² /Day	1% Acetic Acid, 205Å°F, In Vapors
	None	Wet Ammonia Gas, Room Temperature, Closed Container
	None	Dry Ammonia Gas, Room Temperature, Closed Container

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