

FONTARGEN AP 21 AL

Copper high-temperature brazing alloy



DIN EN ISO 17672:	Cu 110
DIN EN 1044:	CU 101
DIN 8513:	L-Cu
EN ISO 3677:	B-Cu100-1085

Composition, typical analysis (% w/w):

Cu
99.9

Mechanical and physical properties:

Working temperature:	1100 - 1150 °C
Melting range:	1083 °C
Gap width:	≤ 0.15 mm
Viscosity range:	120.000 - 145.000 mPas
Metal content:	≈ 89 % w/w
Tensile strength:	316 N/mm ² (Assembly gap 0.05mm)
(Steel St 37-2 / Tensile test according to DIN50145)	272 N/mm ² (Assembly gap 0.15mm)

Characteristics / Applications:

Flux-free copper brazing paste with high metal content. The paste has a medium viscosity and dries very slowly on air. Suited for unalloyed, low-alloyed and high-alloyed steel as well as nickel and nickel alloys. Easy to dispense and good adherence on the workpiece. Suitable for thin and thick workpieces.

Application:

Manually or automatically with pneumatical or mechanical dispensing units.

Heat sources:

Inert-gas continuous furnace Exogas	Inert-gas continuous furnace H ₂ /N ₂	Inert-gas continuous furnace Cracked ammonia atmosphere
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

Availability:

Paste	Powder
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

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