

FONTARGEN AP 21 AL C

Copper high-temperature brazing alloy



EN ISO 17672:	Cu 110
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:	145.000 - 165.000 mPas
Metal content:	≈ 89 % w/w

Characteristics / Applications:

Flux-free copper brazing paste with high metal content. The paste has a medium viscosity and dries slowly on air. Suitable for workpieces made of unalloyed, low-alloyed and high-alloyed steel. Easy to dispense and good adherence on the workpiece.

Application:

Manually or automatically with pneumatical or mechanical dispensing units.

Heat sources:

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

Availability:

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

13/10/JL/1