

FONTARGEN AP 21 CL-5

Copper high-temperature brazing alloy



ISO 17672:	Cu 141
DIN EN 1044:	CU 104
DIN 8513:	L-SFCu
EN ISO 3677:	B-Cu100(P)-1085

Composition, typical analysis (% w/w):

Cu
99.9

Mechanical and physical properties:

Working temperature:	1100 - 1150 °C
Melting range:	1083 °C
Gap width:	≤ 0.1 mm
Viscosity range:	150.000 - 165.000 mPas
Metal content:	≈ 85 % w/w

Characteristics / Applications:

Flux-free brazing paste with high metal content. The paste has a high viscosity and dries slowly on air. Suitable for workpieces made of unalloyed and alloyed steel.

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"/>

13/10/JL/1