

# FONTARGEN AP 21 CL

## 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:	≈ 87 % w/w
Tensile strength:	371 N/mm <sup>2</sup> (Assembly gap)
(Steel St 37-2 / Tensile test according to DIN50145)	356 N/mm <sup>2</sup> (Assembly gap)

### Characteristics / Applications:

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

### Heat sources:

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

### Application:

Manually or automatically with pneumatical or mechanical dispensing units.

### Availability:

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

13/10/JL/1