

# FONTARGEN AP 21 CLP (CS)

## Copper high-temperature brazing paste



|                  |                 |
|------------------|-----------------|
| DIN EN 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:   | ≤ 0.15 mm                                   |
| Viscosity range:                                     | 175.000 - 185.000 mPas                      |
| Metal content:                                       | ≈ 87 % w/w                                  |
| Tensile strength:                                    | 371 N/mm <sup>2</sup> (Assembly gap 0.05mm) |
| (Steel St 37-2 / Tensile test according to DIN50145) | 356 N/mm <sup>2</sup> (Assembly gap 0.15mm) |

### 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, alloyed and high-alloyed steel.

### Application:

Manually or automatically with pneumatical or mechanical dispensing units.

### Heat sources:

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

### Availability:

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

13/10/JL/1