

### TECHNICAL DATA SHEET 40

#### Specifications:

Alloy	Working Temperature (°C)	NF EN ISO 17672	AWS A-5.8	DIN 8513	EN ISO 3677
Cu-Zn-Ni-Ag	890	-	-	-	-

#### Characteristics:

**SUPER-NICROX** is high quality braze welding alloy with 1% Silver as compared to NICROX 49C1. The addition of Silver lowers the melting temperature while producing good capillary action and gives strong joint. Bare rods are to be used or coated with our **POLYFLUX**. Braze Welding alloy with good flowing properties. Being a high Zn content, it is recommended to keep the heating cycle to a minimum to prevent Zinc vaporisation.

#### Applications:

**SUPER-NICROX**, is recommended for brazing High stress joints, primarily used for joining of Steel to Steel or Carbide to Steel. This brazing alloy is also recommended for joining: Steels, Moulded steels, Nickel and Nickel alloys Coppers, Bronze, Brass, Nickel silver, Cupro-aluminium, with its solidus temperature is >900°C.

#### Typical Chemical Compositions (%):

Cu	Zn	Ni	Si	Mn	Sn	Ag	Fe	Al /As	Bi/ Sb /Cd	Pb	Max. impurities
48.00	Balance	9.00	<0.4	<0.2	<0.40	1.00	<0.25	<0.01	<0.01	<0.025	<0.20




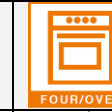
#### Typical Physical Properties:

Coating Colour	Solidus (°C)	Liquidus (°C)	Density g/cm <sup>3</sup>	Elongation %	Tensile strength (MPa)	Electrical Conductivity (%IACS)	Electrical Resistivity (Micro-ohm-cm)
Yellow	870	900	8.70	25%	750	-	-

#### Properties of Brazed Joint:

The properties of a brazed joint dependent upon numerous factors including base metal properties, joint design, metallurgical interactions between the base metal and the filler metal. This alloy needs a controlled quench (in excess of 300°C) to avoid the weakening of the brazed joint.

#### Standard Size, Types & Heat Source Recommendations:

Size (mm)	Type				Type	 OXY/ACETYLENE	 INDUCTION	 AÉRO-PROPANE	 FOUR/OVEN
	Bare	Coated	Coil	Preforms					
1.50,2.00,2.50,3.00, 4.00, 5.00	√	√	√	X	Bare	√	√	X	√
					Coated	√	X	X	√

Customised size other than above standard dimensions are solicited case to case basis

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