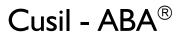


#### **Data Sheet**



#### **Description:**

High-purity Active Braze Alloy of silver, copper and titanium developed for direct application to ceramic surfaces. Nominal composition by weight: 63.0% Ag, 35.25% Cu, and 1.75% Ti

#### **Prime Features:**

- Wets and bonds to virtually any metallic surface, as well as to nonmetallics such as oxides, nitrides and carbides
- Allows ceramic-to-ceramic and ceramic-to-metal surfaces to be brazed without metallizing, firing and electroplating
- Cuts time and costs in manufacture of ceramic/metal assemblies
- · Produces strong, highly reliable and vacuum-tight brazed joints

**Recommended Brazing Atmospheres** 

# Physical Properties\*

# **Typical Applications:**

• One step bonding to ceramics

# Suggested base materials:

• Copper, Kovar, Nickel, Carbon/ low alloy & Tool/high speed steel, Stainless steel, Ni-super alloys, Titanium, Refractory metals, Ceramics, Graphite, Diamond, Tungsten Carbide

Liquidus Temperature	815 °C
	I 500 °F
Solidus Temperature	780 °C
	1435 °F
Coefficient of Thermal Expansion (CTE)	18.5 x 10 <sup>-6</sup> /C, for 20 – 500 °C
	10.3 x 10 <sup>-6</sup> /°F, for 68 – 932 °F
Thermal Conductivity (Calculated)	180 W/m·K
	I04 BTU/ft⋅h⋅ °F
Density	9.8 Mg/m <sup>3</sup>
	0.354 lb/in <sup>3</sup>
Yield Strength (0.2% offset)	271 MPa
	<b>39.9</b> x 10 <sup>3</sup> lb/in <sup>2</sup>
Tensile Strength	346 MPa
	50.2 x 10 <sup>3</sup> lb/in <sup>2</sup>
Elongation (2in/50mm gage section)	20%
Electrical Resistivity	44 x 10⁻⁰ ohm m
Electrical Conductivity	23 x 10 <sup>6</sup> /ohm⋅m
Vapor Pressure (Calculated)	
Recommended Brazing Temperatures	830 – 850 °C

\* Please note that all values quoted are based on test pieces and may vary according to component design. These values are not guaranteed

in any way and should only be treated as indicative values. They should be used for guidance only and for no other purpose whatsoever.

# **Impurity Limits**

Zn	less than 0.001%
Cd	less than 0.001%
РЬ	less than 0.002%
Р	less than 0.002%
С	less than 0.01%

All other metallic impurities having a vapor pressure higher than  $10^{\text{-7}}$  mm Hg at 500  $^\circ\!C$  are limited to 0.002% each. Impurities having a vapor pressure lower than  $10^{\text{-7}}$  mm Hg at 500  $^\circ\!C$  are limited to a total of 0.075%. (This applies to all forms except powder and extrudable paste.)

# Supplied As:

- Foil
- Wire •
- Powder
- Extrudable paste

10<sup>-5</sup> mm Hg, inert gas

Preforms

The determination as to the adaptability of any Wesgo materials to the specific needs of the Buyer is solely the Buyer's prerogative and responsibility. All technical information, data and recommendations are based on tests and accumulated experience data, which Wesgo believed to be reliable. However, the accuracy and completeness thereof are not guaranteed.



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