

TECHNICAL SHEET

Cu86MnNi2

Product name

Cu86MnNi2

Class of product

Copper based high-temperature brazing alloy

Corresponding standards

ISO 17672	Cu 595
EN 1044	-----
AWS A5.8-04	-----
DIN 8513	-----

Nominal composition (weight %)

Cu:	86
Ni:	2
Mn:	12

Physical and technical properties

Melting range (Solidus – Liquidus):	960 - 990 °C
Brazing temperature:	~ 1.000 °C
Density:	8,8 g/cm ³

Range of application

Cu86MnNi2 is a copper based, high temperature brazing alloy.

It is suitable to join steels, stainless steels, nickel and nickel alloys and cemented carbides.

The alloy offers very good protection against interfacial corrosion when used on stainless steel.

Being zinc-free, and because of its high brazing temperature, Cu86MnNi2 is usually used only in protective atmosphere furnace brazing; furnace atmosphere should have a dew point lower than - 40 °C to ensure good results.

Occasionally the alloy can be used also in open air brazing (by flame or by induction), with the use of a proper high temperature flux.

Typical application of Cu86MnNi2 are in the field of carbide and diamond tools.

Characteristics Make-up

Rods
Wires
Strips
Rings
Preforms from Wire and from Strip
Pastes & Powders

NOTE:

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