

TECHNICAL SHEET

Cu60Zn

Product name

Cu60Zn

Class of product

Copper-zinc brazing alloy

Corresponding standards

ISO 17672	Cu 470a
EN 1044	CU 301
AWS A5.8-04	----
DIN 8513	L-CuZn40

Nominal composition (weight %)

Cu:	58,5 - 61,5
Zn:	bal.
Si:	0,2 – 0,4

Physical and technical properties

Melting range (Solidus – Liquidus):	875 - 895 °C
Brazing temperature:	~ 900 °C
Density:	8,4 g/cm ³
Tensile strength (filler metal):	40 kg/mm ²

Range of application

Cu60Zn is a copper-zinc brazing alloy, with little additions of silicon to control zinc vaporization.

It is used to join steels, cast irons, copper and copper alloys, nickel and nickel based alloys and also stainless steel when corrosion resistance is not a major requirement.

When brazing in an oxidizing environment the use of a proper high-temp flux, as BR1 is necessary.

Brazing techniques range from flame to induction.

Cu60Zn is often used for the braze-welding technique with liquid flux spread through the torch flame, by means of vaporizer equipments.

Because of the high zinc content it is recommended to keep the heating cycle to a minimum to prevent zinc vaporization.

Typical applications are found in the tubular constructions industry (metal furniture, bicycle frames, radiators & towel warmers etc.), mining tools, heating and cooling systems, etc.

Characteristics Make-up

Rods:	Ø 1,5 ⇔ 4,0 mm	Length: 500 / 1.000 mm
Flux Coated Rods:	Ø 1,5 ⇔ 4,0 mm	
Wires:	Ø 1,5 ⇔ 4,0 mm	(spooled and coiled)
Rings & Preforms from wire		
Powder and Paste		

Other dimensions are available upon request.

NOTE:

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