

ME186-FA10P

Rev.0 Issue Date: 10-02-2015

Product Specification:

is a copper-nickel brazing filler alloy in paste with an addition of boron and organic binder.

Product features:

is a copper-nickel brazing filler metal with a controlled addition of boron. It was developed for furnace brazing of stainless steel and mild steel under reducing atmospheres where the joint gaps involved cannot be closely controlled. It demonstrates resistance to interfacial corrosion on ferritic and austenitic stainless steels. Nickel facilitates wetting on hard metals and is particularly suitable for filling large gaps.

Norm:

ISO 17672:2016 Cu 186

Chemical Composition:

| Element | Unit | Min % | Max % |
|---------|------|-------|-------|
| Cu | % | 96.50 | 97.50 |
| Ni | % | 2.50 | 3.50 |
| B | % | 0.02 | 0.05 |
| Cd | % | 0.000 | 0.010 |
| Pb | % | 0.000 | 0.025 |
| Al | % | 0.000 | 0.010 |

Physical Properties:

| | |
|--------------------------------|---|
| Working temperature: | 1120 (°C) |
| Melting range: | 1085 - 1100 (°C) |
| Tensile strength: | 400 - 410 (MPa) |
| Viscosity range: | 120000 - 170000 (cP) |
| Metal content: | 89.00 - 91.00 (%) |
| Binder Type: | FA |
| Gap width: | 0,22 mm max |
| Heat sources: | Belt furnaces trough NH ₃ , H ₂ , N ₂ /H ₂ atmosphere |
| Dispensing/Application: | Pneumatic or mechanical dispensing units |

Storage:

The product have a long term storage life but store in a cool and dry place, away from direct sunlight and moisture between 15 ~ 25 °C. Shelf-life 6 months