

ME99XGP-FA10

Rev.0

Product Specification:

Copper paste for brazing containing oxides

Product features:

Suitable for joining low alloy and high alloy carbon steel components and stainless steels, this paste offers the fastest and most economical process for furnace brazing of industrial components. The pasta dries slowly in the air.

Norm:

ISO 17672:2016 Cu 099

Chemical Composition:

Element	Unit	Min %	Max %
Cu	%	98.50	100.00
Cd	%	0.000	0.010
Pb	%	0.000	0.025
Al	%	0.000	0.010
P	%	0.000	0.075
	%	15.000	17.000
	%	0.900	1.100

Physical Properties:

Working temperature:	1095 (°C)
Melting range:	1085 - 1085 (°C)
Tensile strength:	205 - 360 (MPa)
Viscosity range:	600000 - 660000 (cP)
Metal content:	89.00 - 91.00 (%)
Binder Type:	FA
Gap width:	0,10 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 between 15 ~ 25 °C. Shelf-life 12 months