

Technical Datasheet HPW-CuMnCo4

Cadmium free

Norm

DIN EN ISO 17672:2017 -
DIN EN 1044:1999 -
EN ISO 3677:2016 -
DIN 8513:1979 -

Composition [mass friction %]

Cu	Zn	Sn	Mn	Fe	Co
86	-	-	10	-	4

Valid impurity [max. mass friction %]

Al	As	Bi	Cd	Fe	Pb	Sb	total
0.001	0.01	0.01	0.01	0.25	0.025	0.01	0.2

Technical Specifications

Melting range 980-1030 °C
Solidus 980 °C
Liquidus 1030 °C
Working temperature 1020 °C
Density 8.8 g/cm³
Tensile strength not specified

Sources of heat

Inert gas soldering, vacuum soldering

Application

Steels, Nickel, Nickel alloys, Chrome-, Chrome-nickel steels

Delivery forms

Wires	Ø from 0.3 mm to 5.0 mm, available as bunch or on spools
Rods bare	Ø from 1.0 mm to 4.0 mm, in length von 50 mm to 1,000 mm (standard 500 mm)
Rods coated	standard diameter 1.5 mm, 2.0 mm and 3.0 mm; standard 500 mm (available with different thickness of flux)
Bands	from 0.05 mm thickness, maximum width 70 mm
Preforms	made of wires as rings, sections or band components in any shape made of band as discs, shims, blanks, or bent components in any shape
Flux	according to EN 1045 and EN 29454 on request

Other dimensions and forms available on request.