

# Technical Datasheet HPW-CuMnNi



Lote, Lotformteile  
Maschinen- und Vorrichtungsbau  
Brazing Alloys, Brazing Alloy preforms  
Special-purpose Machines, Gauges, Fixtures

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
86	-	-	12	2

## 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 965-1000 °C  
Solidus 965 °C  
Liquidus 1000 °C  
Working temperature 990 °C  
Density 8.8 g/cm<sup>3</sup>  
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.