



ENAR WELD BRAZE PVT. LTD

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ENAR CFB Paste: Copper Furnace Brazing Paste BCuSn4

Unique Features:

A typically formulated paste with 99.9 % + purity fine mesh Copper Alloy Powder having a metal content of 85% weight mixed with special binders.

Advantages:

This Copper Brazing Alloy is usually used for furnace brazing of Mild Steel, 300 & 400 series of Stainless Steels and Carbon Steels and High Alloyed Steels.

Copper Brazing paste has a good fillet forming property which gives a better appearance at the joints. It is recommended to be used in cracked Natural Gas or Propane, H₂/N₂ atmosphere furnaces.

It is ideal for joints for elevated temperature services and for brazing Heat Exchangers and Joining Tubular components providing strong, leak-proof joints.

The brazing process has to be carried out in vacuum or controlled atmosphere.

Brazing Temp: 1040°C

This filler metal is very fluid and works best with joint clearances less than 0.02 to 0.15 MM.

Typical Chemistry of Deposit:

Composition, typical analysis (% w/w):		
Cu	Sn	Pb
93.90 – 94.00	6.00	<0.02

Unique Features:

- Extremely free and thin flowing for maximum capillarity.
- Self-fluxing properties.
- High degree of wetting & bonding.
- Strong, ductile & leak proof joints.

Advantages:

- Highly user friendly while dispensing.
- Precise, economical dosage even on small components.
- Pre-paste components can be stored for several hours prior to brazing operation.
- Clean binder with minimum smoke generation during furnace brazing.
- No post treatment or cleaning required after brazing

Application / Dispensing:

- Manually or automatically with pneumatical or mechanical dispensing units

Physical Properties:

Color:	Orange-Brown
Specific Gravity:	8.92
Density:	0.32 lb/in ³
Electrical Conductivity:	101% IACS
Electrical Resistivity:	1.71m Ω

Standard Packing : 5 / 10 Kgs. Plastic Pails.