

VITROBRAZE®

VZ2133

Specifications

| DIN EN ISO 17672 | AWS A5.8 | AMS | MSRR 9500 |
|---------------------|----------|------|--------------|
| Ni 630 | BNi-3 | 4778 | -114 |

Nominal composition (wt.%)

| Ni | Fe | Cr | Si | B | C | P | Co | Al | S | Ti | Zr | Se |
|-------------------|----|----|-----|-----|-------|-------|------|-------|-------|-------|-------|--------|
| Balance (92.4) | – | – | 4.5 | 3.1 | ≤0.06 | ≤0.02 | ≤0.1 | ≤0.05 | ≤0.02 | ≤0.05 | ≤0.05 | ≤0.005 |

Physical properties

| Property | Unit | Value | Available foil geometry |
|---------------------------------|--|------------------------------|-------------------------|
| Density (amorphous) | g/cm ³ (lb/in ³) | 7.96 (0.288) | |
| Solidus temperature | °C (°F) | 980 (1795) | |
| Liquidus temperature | °C (°F) | 1040 (1905) | |
| Recommended brazing temperature | °C (°F) | 1060 – 1180 (1940 – 2155) | |

Technological properties

| | |
|-----------------------------|---|
| Brazing conditions | The brazing process has to be carried out in a vacuum or protective atmosphere like argon or pure dry hydrogen. |
| Corrosion resistance | Good |
| Field of application | Joining of steel and stainless steel, nickel and cobalt alloys and special metals and their alloys. |

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