

TECHNICAL SHEET

Cu67MnNi9

BEIDUO® Alloys

Providing Complete Brazing, Soldering & Welding

No.:000391

Classification

Copper based high temperature brazing alloy
Cu67MnNi9

Chemical Composition: %

Cu	Mn	Ni	Other
Balance	24	9	0.30

Mechanical and physical properties

Working temperature: 965 °C

Melting range: 950 - 955 °C

Specific gravity: 8.2 g/cm³

Welding process:

Brazing

Description and Applications

It is suitable to join steels, stainless steels, nickel and nickel alloys and cemented carbides. The alloy offers very good protection against interfacial corrosion when used on stainless steel. Being zinc-free, and because of its high brazing temperature, Cu67MnNi9 is usually used only in protective atmosphere furnace brazing; furnace atmosphere should have a dew point lower than - 40 °C to ensure good results. Occasionally the alloy can be used also in open air brazing (by flame or by induction), with the use of a proper high temperature flux. Typical application of Cu67MnNi9 are in the field of carbide and diamond tools.

Availability

Rods: ϕ 1.5-5.0mm Max.Length: 15mm-1000mm

Wire: ϕ 1.2, 1.6mm on spools or coil wire

Other dimensions are available upon request

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