Product Specification Sheet

PSS

ME186-LBV

Rev.0

Product Specification: is a copper-nickel brazing filler alloy in paste with an addition of boron and thixotropyc organic binder

Product features: is a copper-nickel brazing filler metal with a controlled addition of boron. It was developed for furnace brazing of stainless steel and mild steel under reducing atmospheres where the joint gaps involved cannot be closely controlled. It demonstrates resistance to interfacial corrosion on ferritic and austenitic stainless steels. Nickel facilitates wetting on hard metals and is particularly suitable for filling large gaps.

Norm: ISO 17672:2016 Cu 186

Chemical Composition:

Element	Unit	Min %	Max %
Cu	%	96.50	97.50
Ni	%	2.50	3.50
B	%	0.02	0.05
Cd	%	0.000	0.010
Pb	%	0.000	0.025

Physical Properties:

Working temperature:	1120 (°C)
Melting range:	1085 - 1100 (°C)
Tensile strength:	400 - 410 (MPa)
Viscosity range:	90000 - 130000 (cP)
Metal content:	73.80 - 75.80 (%)
Binder Type:	LB
Gap width:	0,18 mm max
Heat sources:	Belt furnaces exothermic protective atmospheres
Dispensing/Application:	Pneumatic or mechanical dispensing units

Storage: The product have a long term storage life but store in a cool and dry place between 15 ~ 25 °C. Shelf-life 12 months