

TECHNICAL SHEET

CuMn38Ni9,5

STELLA
WELDING ALLOYS

Product name

CuMn38Ni9,5

Class of product

Copper based high-temperature brazing alloy

Corresponding standards

ISO 17672 -----
EN 1044 -----
AWS A5.8-04 -----
DIN 8513 -----

Nominal composition (weight %)

Cu: 52,5
Ni: 9,5
Mn: 38

Physical and technical properties

Melting range (Solidus – Liquidus): 880 - 925 °C
Brazing temperature: ~ 935 °C
Density: 7,7 g/cm³

Range of application

CuMn38Ni9,5 is a copper based, high temperature brazing alloy.

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, CuMn38Ni9,5 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 CuMn38Ni9,5 are in the field of carbide and diamond tools.

Characteristics Make-up

Rods
Wires
Strips
Rings
Preforms from Wire and from Strip
Pastes & Powders

NOTE:

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