

Lucas-Milhaupt BRAZE 452

Category : Metal , Nonferrous Metal , Precious Metal , Silver Alloy , Solder/Braze Alloy

Material Notes:

Characteristics: Braze 452 is a free-flowing, low temperature filler metal commonly used to replace cadmium-bearing filler metals of similar silver content. This alloy is best suited for narrow gap applications. (.001-.005" clearance). Handy Flux or Handy Flux Type B-1 should be used with this alloy. **Applications:** Braze 452 is a good, general purpose, low temperature filler metal used in cadmium-free brazing applications. It offers an excellent compromise between low melting point and moderate silver content. For improved corrosion resistance in stainless steel joints, use an alloy such as Braze 505 which contains a small amount of nickel. **Specifications:** Braze 452 conforms to the following specifications- AWS A5.8 BAg-36 Information provided by Lucas-Milhaupt, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Lucas-Milhaupt-BRAZE-452.php

Physical Properties	Metric	English	Comments
Density	9.20 g/cc	0.332 lb/in ³	

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	193 - 228 MPa	28000 - 33000 psi	Copper butt joint
	241 - 310 MPa	35000 - 45000 psi	Brass butt joint
	379 - 448 MPa	55000 - 65000 psi	Low Carbon Steel butt joint
	552 - 586 MPa	80000 - 85000 psi	304 Stainless Steel butt joint
Elongation at Break	2.0 - 5.0 %	2.0 - 5.0 %	% in 2", 304 Stainless Steel butt joint
	8.0 - 13 %	8.0 - 13 %	% in 2", Low Carbon Steel butt joint
	15 - 30 %	15 - 30 %	% in 2", Brass butt joint
	25 - 35 %	25 - 35 %	% in 2", Copper butt joint

Thermal Properties	Metric	English	Comments
Melting Point	640.0 - 681.1 Â°C	1184 - 1258 Â°F	
Solidus	640.0 Â°C	1184 Â°F	Melting Point
Liquidus	681.1 Â°C	1258 Â°F	Flow Point

Component Elements Properties	Metric	English	Comments
Copper, Cu	26 - 28 %	26 - 28 %	
Other, total	<= 0.15 %	<= 0.15 %	

Component Elements Properties	Metric	English	Comments
Tin, Sn	2.5 - 3.5 %	2.5 - 3.5 %	
Zinc, Zn	23 - 27 %	23 - 27 %	

Electrical Properties	Metric	English	Comments
Electrical Resistivity	0.00000960 ohm-cm	0.00000960 ohm-cm	

Processing Properties	Metric	English	Comments
Processing Temperature	680.0 - 816 Â°C	1256 - 1500 Â°F	Brazing Range

Descriptive Properties	Value	Comments
Color	Pale Yellow	

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