



## Dispensable Pastes for Furnace Brazing

Copper Brazing Pastes							
Paste Type	Composition (wt.-%)			Melting-range °C	Optimum Brazing Temperature °C	Base Materials Areas of Application	Furnace Atmos- pheres
	Cu	Sn	others				
ML 100	100	-		1083	1120	steels, Ni and Ni-alloys	ABCD
ML 103	98	-	2 Fe	1083	1120	steels, Ni and Ni-alloys good bridging proper- ties for wider gaps	ABCD
ML 104	96	4		960-1060	1090	steels, Ni and Ni-alloys	ABCD
ML 106	94	6		910-1040	1060	steels, Ni and Ni-alloys	ABCD
ML 200	88	12		820-990	1040	steels, Ni and Ni-alloys copper and higher melting copper alloys	ABCD
ML 320	80	20		800-890	950-1000	copper and copper alloys	ABCD
ML 422	87	-	10 Mn 3 Ni	970-1030	1080	cemented carbides	AC
ML 423	87	-	10 Mn 3 Co	980-1030	1080	cemented carbides	AC
ML 937	94	-	6 P	710-890	850	copper and Cu alloys	AC
ML 986	86	7	7 P	650-700	840	copper and Cu alloys	AC

### Furnace atmospheres:

- A= dry hydrogen
- B= vacuum
- C= cracked ammonia (H<sub>2</sub> + N<sub>2</sub> mixture)
- D= exothermic atmosphere

Other alloys, conditionings and dimension on request

## Nickel Based Brazing Pastes

Paste Type	DIN EN 1044	Composition ( wt.-%)					Melting-range °C	Optimum Brazing Temperature °C	Furnace Atmospheres
		Ni	Cr	Si	B	other			
ML 4119	NI 101	Rest	14	4,5	3,1	4,5 Fe 0,75 C	980-1060	1175	A B
ML 4127	NI 1A1	Rest	14	4,5	3,1	4,5 Fe	980-1070	1175	A B
ML 4121	NI 102	Rest	7	4,5	3,1	3 Fe	970-1000	1060	A B
ML 4124	NI 103	Rest	-	4,5	3,1	-	980-1040	1060	A B
ML 4125	NI 104	Rest	-	3,5	1,9	-	980-1070	1120	A B
ML 4116	NI 105	Rest	19	10	-	-	1080-1135	1190	A B C
ML 4146	NI 106	Rest	-	-	-	11 P	875	1000	A B C D
ML 442	NI 107	Rest	14	-	-	10 P	890	1020	A B C
ML 429	NI 108	Rest	-	7	-	23 Mn 4,5 Cu	980-1010	1060	A C
ML 4109	NI 109	Rest	15	-	3,6	-	1055	1175	A B

## Silver Based Brazing Pastes

Paste Type	DIN EN 1044	Composition ( wt.-%)			Melting-range °C	Optimum Brazing Temperature °C	Base Materials	Furnace Atmospheres
		Ag	Cu	other				
ML 530	-	Rest	70	-	780-950	980	Steels, Copper and Cu-alloys	A B C D
ML 556	AG 102	Rest	22	5 Sn 17 Zn	620-650	740	Brass Copper/ brass	A C
ML 572	AG 401	Rest	28	-	780	870	Steels Cu- and Ni-alloys	A B C D

### Furnace atmospheres:

- A= dry hydrogen
- B= vacuum
- C= cracked ammonia (H<sub>2</sub> + N<sub>2</sub> mixture)
- D= exothermic atmosphere

Other alloys, conditionings and dimensions available on request



### Other products

Filler metal wire, strips and preforms for the flux-free furnace brazing under atmosphere and in vacuum. Economical solutions for mass production.