

Bellman-Melcor LLC
 7575 West 183rd Street
 Tinley Park, Illinois 60477
Phone: 1-800-367-6024 • **Fax:** 1.888.BRAZE-IT-272.9348
Email: sales@bellmanmelcor.com • **Website:** www.bellmanmelcor.com



Item # Brazelt 102, Copper & Copper Brazing Alloys

High purity copper brazing alloy for furnace and vacuum brazing. Provides outstanding strength on steel, stainless, and nickel alloys. This brazing alloy provides high liquidity so it works great with tight fitting parts.

Brazelt #102 is an oxygen-free, highly liquid brazing alloy. It is ideal for steel, stainless and nickel alloys. Brazing is performed in either a controlled atmosphere or a vacuum. Brazelt #102 delivers superior strength (in excess of 75,000 PSI for properly designed joints) and is very ductile. Available in a variety of brazing preform options, Brazelt #102 is best suited for press-fit joints. This makes it possible to produce high strength components with a minimum amount of braze alloy.

[Nominal Composition](#) · [Specifications](#) · [Physical Constants](#) · [Applications](#)

Nominal Composition

Copper (Cu)	99.95%
--------------------	--------

Specifications

Material	OFHC
Melting Pt.	1981 °F 1083 °C
Flow Pt.	1981 °F 1083 °C
MBT	2050
Federal Specification	QQ-B-575
Preform Options	Brazing Discs Brazing Rings Brazing Shims Brazing Spheres Brazing Washers Custom Shapes Cutoffs Edgewounds
Resale Options	Brazing Paste Brazing Rod Brazing Strip Brazing wire Spooled Brazing Material
Pricing & availability	Our material sources offer us the best combination of quality, price and service. This translates into high performance brazing alloys for the customer delivered on time and at highly competitive prices.
Approx. Wire Length (BCuP/lb.) (BAg/Tr.oz)	1025 in @ 0.062 diameter 4100 in @ 0.031 diameter 456 in @ 0.093 diameter

Physical Constants

Solidus	1981 °F 1083 °C
Liquidus	1981 °F 1083 °C
Brazing Range	2050 °F

Specific Gravity	8.94
Density	0.323 lb./cu.in
Electrical Conductivity	1.01 % IACS
Electrical Resistivity	1.71 Micro ohm-cm
Color	Copper

Applications

For vacuum and specialty furnace brazing applications with steel and stainless where high purity and dew point control are important.