

Brazelt #681 (Low Fuming Bronze)

Nominal Composition:	
Copper	58%
Iron	.75%
Tin	8%
Zinc	Balance
Physical Constants:	
Solidus	1580°F (868°C)
Liquidus	1620°F (882°C)
Brazing Range	1700°F
Density (lb/cu in)	.302

DESCRIPTION:

Brazelt #681 is a versatile alloy suited for the joining of steel, copper, copper alloys, nickel, nickel based alloys, and stainless steel where corrosion resistance is not a major requirement. This alloy has gained popularity as an economical alternative to silver based alloys. Most commonly brazed via torch or induction, it is best to keep the heat cycle to a minimum to prevent vaporizing the zinc. Flux is required when brazing with CDA #681. Ultra Flux is well suited for most applications. Also a vapor type flux introduced through a torch flame is a popular supplement in many production applications.

SPECIFICATIONS:

AWS	R-CUZNC
MIL	R-19631
FED. SPEC.	QQ-B-571a
ASTM	B259

AVAILABLE FORMS:

Standard forms of Brazelt #6811 are wire, strip and preforms.