

PREMABRAZE® 800

NOMINAL COMPOSITION

Gold	80.0% ± 1.0%
Tin	20.0% ± 1.0%

PHYSICAL PROPERTIES

Color	Gold Silver
Melting Point (Solidus)	536°F (280°C)
Flow Point (Liquidus)	536°F (280°C)
Soldering Temperature Range	599°F - 644°F (315°C - 340°C)
Specific Gravity	14.54
Density (Troy oz/in ³)	7.66
Electrical Conductivity (%IACS) ⁽¹⁾	8.30
Electrical Resistivity (Microhm-cm)	20.8

⁽¹⁾ IACS = International Annealed Copper Standard

PRODUCT USES

Premabraze 800 can be used on any of the common ferrous and non-ferrous alloys. Typical applications include soldering of electronic components requiring low vapor pressure filler metal. Due to its low melting point, this alloy can be used in conjunction with soldering alloys in step solder operations.

BRAZING CHARACTERISTICS

Premabraze 800 is a low ductility, low vapor pressure alloy used in cases where use of lead or silver is not permissible.

PROPERTIES OF SOLDER JOINTS

The properties of a solder joint are dependent upon the base metal, joint design and soldering technique. For controlled atmosphere soldering or vacuum soldering the recommended radial joint clearance for gold solder alloys fall within 0.000 in. - 0.002 in. (0.00 mm - 0.05 mm.).

AVAILABLE FORMS

Strip, engineered preforms, specialty preforms per customer specification.

SPECIFICATIONS

Premabraze 800 alloy conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 18-800.

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information, refer to the Material Safety Data Sheet for Premabraz 800.

WARRANTY CLAUSE

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