

PREMABRAZE[®] 127

NOMINAL COMPOSITION

Gold	35.0% ± 0.5%
Copper	Remainder
Nickel	3.0% ± 0.5%
Zinc	0.001% Max
Cadmium	0.001% Max
Lead	0.002% Max
Phosphorus	0.002% Max
Carbon	0.005% Max
Other high vapor pressure elements each ⁽¹⁾	0.001% Max
Total all high vapor pressure elements (Including zinc, cadmium, and lead)	0.010% Max
Total all other impurity elements	0.01% Max

⁽¹⁾ Elements with a vapor pressure higher than 10⁻⁷ Torr (1.3 x 10⁻⁵ Pa) at 932°F (500°C)

PHYSICAL PROPERTIES

Color	Red Gray
Melting Point (Solidus)	1814°F (990°C)
Flow Point (Liquidus)	1850°F (1010°C)
Brazing Temperature Range	1850°F - 1950°F (1010°C - 1070°C)
Specific Gravity	11.01
Density (Troy oz/in ³)	5.80
Electrical Conductivity (% IACS) ⁽²⁾	13.5
Electrical Resistivity (Microhm-cm)	12.8

⁽²⁾ IACS = International Annealed Copper Standard

PRODUCT USES

Premabraz 127 can be used on any of the common nickel, molybdenum and iron base heat resistant alloys. Because of its low penetration of the base metal, it is well suited for brazing of thin sections, such as thin-wall tubing or electronic vacuum devices. Premabraz 127 is readily used in brazing of nickel-cobalt-iron alloys and metallized ceramics.

BRAZING CHARACTERISTICS

Premabraz 127 is a modified gold-copper alloy. The addition of nickel renders this alloy somewhat more sluggish in flow characteristics but improves wettability on ferrous alloys. Premabraz 127 is generally used in a vacuum, or a reducing, or inert atmosphere. It is a more ductile alloy and less susceptible to hydrogen embrittlement than standard gold-copper alloys. Premabraz 127 is less likely to penetrate the grain boundaries of glass sealing such as nickel-cobalt-iron alloys in comparison to standard gold-copper alloys. The composition of the alloy allows for use in applications where braze filler metals low in volatile constituents are required. A minimum brazing temperature of 1885°F (1030°C) is suggested for furnace brazing in hydrogen or dissociated ammonia having a -40°F dew point or drier on 300 and 400 series stainless steels which do contain any intentionally added Ti or Al elements.

PROPERTIES OF BRAZED JOINTS

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

AVAILABLE FORMS

Wire, strip, engineered preforms, specialty preforms per customer specification, powder and paste.

SPECIFICATIONS

Premabraz 127 alloy conforms to the following specifications:

- American Welding Society (AWS) A5.8/A5.8M BAu-3
- American Welding Society (AWS) A5.8/A5.8M BVAu-3 Grade 1 and Grade 2 (Chemistry Only)
- ASME Boiler & Pressure Vessel Code, Sec II-C, SFA-5.8 BAu-3

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for Premabraz 127: A00000290, Legacy Code: 18-127.

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 Safety Data Sheet for Premabraz 127.

WARRANTY CLAUSE

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