

PREMABRAZE[®] 880

NOMINAL COMPOSITION

| | |
|-------------------------------|--------------|
| Gold | 88.0% ± 0.5% |
| Germanium | 12.0% ± 0.5% |
| Non-Volatile Elements (Total) | 0.03% Max |

PHYSICAL PROPERTIES

| | |
|--|-------------------------------|
| Color | Gold |
| Melting Point (Solidus) | 673°F (356°C) |
| Flow Point (Liquidus) | 673°F (356°C) |
| Brazing Temperature Range | 673°F - 773°F (356°C - 412°C) |
| Specific Gravity | 14.68 |
| Density (Troy oz/in ³) | 7.74 |
| Electrical Conductivity (%IACS) ⁽¹⁾ | 9.20 |
| Electrical Resistivity (Microhm-cm) | 18.7 |

⁽¹⁾ IACS = International Annealed Copper Standard

PRODUCT USES

Premabraze 880 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 where use of solder filler metal is not allowable.

BRAZING CHARACTERISTICS

Premabraze 880 is a low ductility alloy used in cases where both use of lead or silver is not permissible. Premabraze 880 will not directly wet stainless steel, therefore nickel plating of the stainless steel substrate is recommended.

PROPERTIES OF SOLDER JOINTS

The properties of a soldered 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 880 alloy conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 18-880.

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 880.

WARRANTY CLAUSE

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