

Meta-Braze™ Cu186

Copper Nickel Brazing Filler Metal

Meta-Braze Cu 186™ is a copper-nickel brazing filler metal with a controlled addition of boron. It is principally intended for furnace brazing of stainless steel and mild steel in vacuum or under reducing atmospheres. It provides a useful alternative to brazing with OFHC copper in situations joint gaps involved cannot be closely controlled as it can successfully bridge gaps ranging from an interference fit up to 0.5mm.

Standard	ISO 17672:2016 Cu 186	Reference Standard EN 1044 Cu 105
Melting Range	1085°C - 1100°C	Brazing Temperature: 1110°C
Chemical Composition	Copper Nickel Boron Impurities as per ISO 17672 Table 1	Balance 3% 0.03%
Conditions for Use	Recommended Processes: Vacuum or Reducing Atmosphere Recommended Gap Size: - 0.0mm – 0.5mm (0.000 – 0.020")	
Physical Properties	Density – 8.9g/cm ³ Tensile Strength – 300MPa	
Forms of Supply	Wire – Powder – Paste	

