

FONTARGEN AF 210K

BRASS BRAZING ALLOY

High strength brazing alloy, flux coated

Fontargen AF 210K is a nickel brazing filler metal of high strength and good fluidity. Suitable for brazing of steel, cast iron malleable cast iron, nickel and nickel alloys. Also suitable for brazing and hardening in one production step. It's very often used in the steel furniture and tubing industry.

Product features	Product benefits	User benefits
» High tensile strength	» Suitable for parts subject to dynamic forces	» Perfect for steel to steel applications
» Good matching color with brass	» Good visual aspect after brazing	» Identical coloring with brass
» High service temperature	» No loss of strength at high temperatures (until 300°C)	» Possible usage on parts serviced at higher temperature
» Small melting range	» Good flow properties	» Good capillarity effect, high quality of the joining » Fast brazing process



Typical applications

- » Heating element
- » Furniture and tubing industry
- » Bicycle industry
- » Global repairs (machinery, handicraft)

Mainly used for

- » Parts subject to diverse dynamics forces: (vibrations, dilatation, etc...)
- » Parts where coloring matching with brass is important

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Classification			
AWS A5.8	EN ISO 17672	EN 1044	DIN 8513
-	Cu671	CU306	L-CuZn39Sn

Typical chemical composition, wt. %					
Cu	Sn	Zn	Si	Ni	Mn
59	1	Bal.	0.3	0.85	0.6

Mechanical properties					
Working Temperature	Melting Range	Specific weight	Elongation	Operating service temperatures of the joint	Max. service temperatures of the joint
900°C	870°C/890°C	8.4 g/cm ³	30%	-200°C/+300°C	300°C

Base materials
Steel, cast iron, malleable cast iron, nickel, nickel alloys

Heat sources
Open flame, Induction, Resistance

Flux
FH 21 acc. to EN 1045 => F100 Series of Fontargen

Art. Nr.	Form	Dimensions (mm)	Packaging
82266	Rods	2.0 x 500	5 kg box

