

## Braze alloy quick reference chart

Amdry™ product	Solidus		Liquidus		Braze range		Recommended gap size		Gap capability *	Corrosion resistance	Ductility
	°C	°F	°C	°F	°C	°F	mm	in			
100/100C/100F	1080	1975	1135	2075	1150 – 1205	2100 – 2200	0.0125 – 0.10	0.0005 – 0.004	Narrow	Excellent	Good
103	1080	1975	1135	2075	1165 – 1205	2125 – 2200	0.10 – 0.255	0.004 – 0.010	Wide	Excellent	Good
105	993	1820	1010	1850	1066 – 1121	1950 – 2050	0.0125 – 0.10	0.0005 – 0.004	Narrow	Excellent	Good
400	1120	2050	1150	2100	1150 – 1230	2100 – 2250	0.0125 – 0.10	0.0005 – 0.004	Narrow	Excellent	Good
718B	1105	2020	1230	2250	1230 – 1275	2250 – 2325	0.05 – 0.375	0.002 – 0.015	Wide	Excellent	Good
770/7701/7703	970	1780	1000	1830	1010 – 1175	1850 – 2150	0.08 – 0.125	0.003 – 0.005	Normal	Excellent	Good
775	1020	1870	1050	1925	1065 – 1205	1950 – 2200	0.0125 – 0.10	0.0005 – 0.004	Narrow	Excellent	Excellent
780/7801	980	1800	1040	1900	1010 – 1175	1850 – 2150	0.0125 – 0.10	0.0005 – 0.004	Normal	Good	Excellent
788	1160	2120	1240	2265	1220 – 1260	2225 – 2300	0.05 – 0.15	0.002 – 0.006	Normal	Excellent	Good
790/7901	1054	1930	1093	2000	1080 – 1205	1980 – 2200	0.05 – 0.50	0.002 – 0.020	Wide	Good	Excellent
805	1075	1965	1105	2020	1150 – 1200	2100 – 2195	0.025 – 0.10	0.001 – 0.004	Normal	Good	Good
915	960	1760	1125	2060	1135 – 1205	2075 – 2200	0.05 – 0.50	0.002 – 0.020	Wide	Excellent	Very Good
9150	977	1790	1075	1970	1075 – 1205	1970 – 2200	0.05 – 0.50	0.002 – 0.020	Wide	Excellent	Very Good
9300/9301/9300B	980	1800	1010	1850	1010 – 1095	1850 – 2000	0.0125 – 0.10	0.0005 – 0.004	Narrow	Good	Excellent
B-93	1095	2000	1190	2210	1190 – 1225	2175 – 2235	0.05 – 0.10	0.002 – 0.004	Narrow	Excellent	Good
BRB	1055	1931	1120	2048	1175 – 1230	2150 – 2250	0.05 – 0.50	0.002 – 0.020	Wide	Excellent	Good
D-15	1095	2000	1165	2125	1175 – 1220	2150 – 2230	0.05 – 0.25	0.002 – 0.010	Normal	Excellent	Good
DF-3	1050	1920	1120	2050	1190 – 1220	2175 – 2225	0.05 – 0.10	0.002 – 0.004	Normal	Excellent	Good
DF-4B	1065	1950	1120	2050	1150 – 1190	2100 – 2175	0.05 – 0.25	0.002 – 0.010	Wide	Excellent	Good
DF-6A	1050	1920	1155	2115	1170 – 1220	2140 – 2225	0.05 – 0.25	0.002 – 0.010	Wide	Excellent	Good
MM509B (-C & -F)	1130	2065	1165	2130	1175 – 1260	2150 – 2300	0.05 – 0.10	0.002 – 0.004	Normal	Excellent	Good

\* Many braze alloys can achieve wide-gap capability with the addition of a standard or superalloy filler material, also available from Oerlikon Metco.

Information is subject to change without prior notice.