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CDA 681 (RBCuZn-C) TECHNICAL DATA

NOMINAL COMPOSITION	Copper	58.0% ± 2.0
	Zinc	Remaining
	Iron	0.75% ± 0.45
	Tin	0.95% ± 0.15
	Manganese	0.255% ± 0.245
	Lead	0.05% Max
	Aluminum	0.01% Max
	Silicon	0.095% ± 0.055
	Other Elements, Total	0.50% Max
PHYSICAL PROPERTIES	Color	Brass Yellow
	Solidus	1590°F (866°C)
	Liquidus	1630°F (888°C)
	Recommended Brazing Temperature	1680-1730°F (915-943°C)
	Density (lbs./in³)	0.30
	Specific Gravity	8.36
	Electrical Conductivity (%IACS)	24.0
	Electrical Resistivity (Microhm-cm)	7.18
USES	CDA 681 is a low fuming bronze filler metal used for brazing of ferrous and non-ferrous alloys such as steel and copper. This alloy is typically used where close fit up cannot be maintained and high brazing temperatures are permissible.	
BRAZING CHARACTERISTICS	CDA 681 has good wetting characteristics on ferrous and non-ferrous materials particularly steels and coppers. Maximum strength and joint integrity are obtained where joint clearance falls within the range of 0.003in – 0.005in per side. Heating methods include torch, induction and furnace.	
PROPERTIES OF BRAZED JOINTS	The properties of a brazed joint are dependent upon numerous factors including base metal properties, joint design, metallurgical interaction between the base metal and the filler metal.	
SPECIFICATIONS	CDA 681 alloy conforms to: Unified Numbering System (UNS) C68100 and American Welding Society (AWS) A5.8/A5.8M RBCuZn-C	
AVAILABLE FORMS	Wire, strip, engineered preforms, specialty preforms per customer specification, powder and paste.	

Individuals requiring further information and Engineering Specification Documents may wish to contact the Engineering Society for Advanced Mobility, Land Sea Air and Space, The Society of Automotive Engineers <http://www.sae.org/> (SAE AMS) or The American Welding Society (AWS) <http://aws.org/>

NOTE:

DISCLAIMER

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