



## Vitta Braz-Tapes

Classification	Brazing Tapes	Issued July 2019 Revision 1.0
Overview	<p>Vitta-Braz High Temperature Brazing Alloy Transfer Tapes provide a precise method for applying controlled amounts of brazing filler metals or coating alloys in a measured uniform layer.</p> <p>Tapes are composed of a high-density layer containing braze alloy and selected organic binders attached to a plastic carrier. Vitta brazing alloy tapes are available with or without a pressure sensitive adhesive coating. During firing all the organic material is completely decomposed and a measured uniform brazing alloy layer is left on the surface to be joined or protected. Use of the tapes allow an operator to pre-place a measured amount of brazing alloy into the braze joint and to do it consistently. Use of high-quality materials produce clean and consistent braze joints.</p>	
Available Alloys	<p>All filler metals used in the tapes are high-purity, gas-atomised fully certified brazing alloys. Vitta Braz-Tapes are available in different alloy mesh sizes and all the standard alloy designations such as those specified by AMS, AWS, General Electric, Pratt and Whitney, Rolls-Royce, Snecma and others.</p>	
Binders	<p>Vitta-Braz tapes contain less than 9% organic binder. During firing all organic material completely decomposes.</p>	
Typical Application	<p>Vitta brazing tapes are designed for controlled atmosphere furnaces. They offer advantages in every application where precision brazing is required with closely held thicknesses and density values. Typical applications include:</p> <ul style="list-style-type: none"> <li>• Feltmetal seals are usually brazed to stainless steel backing plates with the help of gold-nickel foil. By using nickel-base brazing tapes the cost can be substantially reduced and wicking of the braze alloy eliminated.</li> <li>• Honeycomb Structures are brazed to stainless steel or other special alloys with nickel-based brazing alloys. Previously the brazing materials were “salted” into the honeycomb which depending on the depth and size of the cell structures could prove difficult to produce a satisfactory part. Tapes allow seals to be produce with excellent consistency.</li> <li>• Corrugated Sheets are brazed to backing sheets by nickel-based brazing alloys. Tapes provide a significant advantage by carefully controlling the amount of brazing material in the assembly which prevents squeezing out of the base alloy.</li> <li>• Castings can be made pressure tight by sealing the surface with Vitta-Braz Tapes.</li> </ul>	

	<ul style="list-style-type: none"> <li>• Repairs can be made to engine nozzles and holes plugged in thin sheet metal parts by the use of brazing tape in high-temperature applications.</li> <li>• Worn Parts and thin sections can be built up in selected areas without worrying about edge effect and the thickness of built up areas can be closely controlled by using brazing tapes.</li> </ul>
Braz-Tape Availability	Tapes are supplied in rolls with a standard length of 25' (7.5m) or 50' (15m) to customer specified thickness and a width on a 1.5" ID core or 3" core. Standard thicknesses are from 0.002" (0.05mm) to 0.063" (1.6mm) and widths from 0.2" (5.1mm) to 23.6" (600mm).
Storage Recommendations	<ul style="list-style-type: none"> <li>• Tapes should be stored in their sealed bags to minimise drying.</li> </ul>
Safety Recommendation	Please refer to the specific MSDS (Material Safety Data Sheet) – available from Vitta
Disclaimer	All information provided on our products is based upon our experience and extensive testing and research. Information on these technical data sheets is provided in good faith but does not exempt the user from the requirement to check the data held herein. It is the responsibility of the customer to ensure that the product is suitable for the intended use particularly if the application or process has not been specifically approved by us in writing. Vitta cannot be held liable for any errors or omissions published. Vitta always recommend your internal quality team must approve any proposed usage.