

Cladding composite **BRAFER** (Low carbon steel, single or double side cladded yellow brass)

Brief description

BRAFER is a single or double side cold rolled cladded material composite combining forming and strength properties of low carbon deep drawing steel with physical and decorative properties of yellow brass.

Standard - raw materials

Position	Material	Description	Material-No.	Standard
Core	Unalloyed deep drawing steel	DD14	1.0389	DIN EN 10111
Cladding Layer	Yellow brass	CuZn36 (Ms63)	2.0335	DIN EN 1652

Chemical composition [%]

Steel	C	Mn	P	S	Al
DD14	0.08	0.35	0.025	0.025	0.015 0.070

Copper	Cu	Al	Fe	Ni	Pb	Sn	Zn	Other elements
CuZn36 (CW507L)	63.5 65.5	0.03	0.1	0.3	0.1	0.1	Rest -	- 0.1

Standard sizes

Strip thickness: 0.2 - 2.50 mm
 Strip width: 20 - 630 mm
 Cut-to-length: 500 - 2.000 mm

Cladded layers and adhesion

Nominal layer thickness: Double-sided 5/5 or 10/10 % of strip thickness, alternatively one-sided or difference cladding on request

Adhesion: Not possible to strip off the cladded layer from the steel core

Measuring of the layer thickness: Magnetic force. metallographic or gravimetric

Surface quality

Type/description	Characteristics	Roughness Ra
bright	Bright, metallicly clean surface. Pitting, grooves and scratches are permitted as long as the uniform smooth appearance is not essentially impaired when viewed with the naked eye.	< 0.10 µm
regular	Metallicly clean surface, Pitting, minimal defects and scratches are acceptable in a scale not impairing the technical function of the outside layers of the composite material.	0.15 - 0.80 µm
isotropic		1.0 - 2.0 µm

Mechanical properties

Cladded layer Yellow brass [%]	Surface type	Strength condition ¹⁾	Yield stress R _{p0.2} [MPa]	Tensile strength R _m [MPa]	Elongation A ₈₀ [%]
5/5 10/10	regular isotropic	LC	max. 250	max. 370	min.34
5/5 10/10	bright regular isotropic	LC+	200 - 320 180 - 300	300 - 380 280 - 370	min. 30
5/5 10/10	regular	C330 C320	min. 300 min. 280	330 - 420 310 - 410	min. 12
5/5 10/10	regular	C380 C370	--- ---	380 - 480 370 - 470	min. 4

¹⁾ Description LC and Cxxx according to DIN EN 10139

Tolerances

- Size limits of thickness - according to classes A, B, C of DIN EN 10140
- Size limits of width - according to classes A, B of DIN EN 10140
- Size limits of length - according to classes A, B of DIN EN 10140

Edge type

GK according to DIN EN 10140

Delivering types

Strips, sheets

Ordering example

Every order should be specified in consideration of the following information based on this material data sheet:

Product feature	Example 1	Example 2
Cladding composite	BRAFER	BRAFER
Layer material	CuZn36	CuZn36
Cladded layer P(side1-side2) [%]	P(05-05)	P(10-00)
Strength condition	LC	C380
Surface quality	bright	regular
Edge type	GK	GK
Delivering type	Strips	Sheets
Thickness (tolerance) x width (tolerance) x length (tolerance)	0.80 (+/- 0.025) x 100 (+/-0.13) mm	1.20 (+/-0.030) x 420 (+/-0.30) x 1.500 (-0/+6) mm

Miscellaneous

All information in this material data sheet is referring to BRAFER materials based on a standard production. Further product features on request.