



## Brazing alloy in paste BrazeTec 1002/ML4121

TD EN 1002/ML4121 REV. 3

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	-	-	-	4,5	-	-	Rest	7 Cr; 3,1 B; 3Fe	Ni 620	NI 102	-

### Technical data:

Melting range (°C)	970-1000
Working temperature (°C)	1050
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	-
Flash point (°C)	-
Operating temperature of brazed joint (°C)	-
Tensile strength DIN EN 12797 (MPa)	-
Alloy density (g/cm <sup>3</sup> )	8
Paste density (g/cm <sup>3</sup> )	3,9 (20°C)
Metal content (%) of total weight	85
Grain size of brazing alloy powder (µm)	< 106
Viscosity (dPas)	450-650 (Haake Viscotester 02, Sp.2, 20 ± 2°C)
Cleaning agent	Water
Flux type within the paste	Absent
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

### Applications

Refrigeration and air conditioning industry, heating system, automotive

### Operating conditions

Homogeneous mixture of nickel based powder. Finely dissolved in a binder system water based; dosable or spreadable manually. Good flow, capillarity and mechanical strength characteristics. Used for joining steel, stainless steel, nickel, nickel alloys, as well as cobalt, cobalt alloys, and in certain conditions special alloys.

### Heat source

Furnace in vacuum and under protective atmosphere

### Standard packaging

Jar

Not suitable for brazing in nitrogen atmosphere.

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