



Brazing alloy in paste BrazeTec 1080/ML 4127

TD EN 1080/ML4127 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	14 Cr; 3,13 B; 4,5 Fe	Ni 610	NI 1A1	-

Technical data:

Melting range (°C)	980-1070
Working temperature (°C)	1175
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	400 °C to 1 bar
Flash point (°C)	-
Operating temperature of brazed joint (°C)	-
Tensile strength DIN EN 12797 (MPa)	-
Alloy density (g/cm ³)	7,8
Paste density (g/cm ³)	3,9 (20°C)
Metal content (%) of total weight	85
Grain size of brazing alloy powder (µm)	< 63
Viscosity (dPas)	400-550 (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 copper, copper alloys, nickel, nickel alloys, as well as cobalt, cobalt alloys. Also used for non-joined, semi-joined and high-joined steels and in certain conditions special alloys.

Heat source

Furnace in vacuum and under protective atmosphere

Standard packaging

Jar

Packaged in jar or buckets. Must be stirred in case of condensed water on the top.

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