



Brazing alloy in paste BrazeTec 1090

TD EN 1090 REV. 2

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	-	-	-	4	6	-	Rest	30 Cr	-	-	-

Technical data:

Melting range (°C)	980-1040
Working temperature (°C)	1090
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 ³)	-
Paste density (g/cm ³)	3,5 (20°C)
Metal content (%) of total weight	85
Grain size of brazing alloy powder (µm)	<53
Viscosity (dPas)	2,55 ± 0,38 (Cone-Plate; 150 µm; D=1/s; 20 °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 joints in steel, stainless steel, nickel, nickel alloys, cobalt, cobalt alloys, and in certain conditions special alloys.

Heat source

Furnace in vacuum and under protective atmosphere

Standard packaging

Jar
A drying process at temperatures between 90°C and 120°C is required to evaporate water and to ensure a minimum temperature of 70°C of the joint. Brazing process should be carried out at a temperature of 450°C for a certain time to ensure no binder residues by evaporating.

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