



Brazing alloy in paste BrazeTec 1135/ML 4116

TD EN 1135/ML4116 REV. 3

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	-	-	-	10,1	-	-	Rest	19 Cr	Ni 650	NI 105	-

Technical data:

Melting range (°C)	1080-1135
Working temperature (°C)	1190
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)	7,65
Paste density (g/cm ³)	3,7 (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. Excellent 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

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