



Brazing alloy BrazeTec 5507

TD EN 5507 REV. 4

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
55	21	22	2	-	-	-	-	-	Ag 155	AG 103	B-Ag55ZnCuSn 630/660

Technical data:

Melting range (°C)	630 - 660
Working temperature (°C)	660
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	7
Elongation %	25
Density (g/cm ³)	9,4
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with S 235: 350;with E 295: 430
Operating temperature of brazed joint (min/max) ± (°C)	200

Applications

Air conditioning, refrigeration and electrical industry, plumbing technology, precision metal parts, fashion accessories, automotive, spectacle frames (optics), tool industry

Operating conditions

Silver based brazing alloy with excellent flow, capillarity and mechanical strength characteristics. Used for brazing any steels, copper and copper alloys, as well as nickel and nickel alloys.

Recommended fluxes

N1/T, Super 1, N2/E, H paste, H sprayable, RS/A, FN/E, D 98, H spezial, H 80, H 280, H 285

Heat sources

Induction heating, flame, furnace in vacuum and under protective atmosphere

Delivery forms

Wire, rods, ribbon, rings, preforms, powder

Notes

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