Brazing alloy BrazeTec 6002

Composition (% in weight)

<table>
<thead>
<tr>
<th>Ag</th>
<th>Cu</th>
<th>Zn</th>
<th>Sn</th>
<th>Si</th>
<th>P</th>
<th>Mn</th>
<th>Ni</th>
<th>Other</th>
<th>ISO 17672:2010</th>
<th>EN 1044:1999</th>
<th>ISO 3677</th>
</tr>
</thead>
<tbody>
<tr>
<td>60</td>
<td>23</td>
<td>14,5</td>
<td>2,5</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
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</tr>
</tbody>
</table>

Technical data:

- Melting range (°C): 620-685
- Working temperature (°C): 680
- Melting range according to DSC measurement (°C): -
- Min. brazing temperature (°C): -
- Electrical conductivity (m/Ω mm²): -
- Elongation %: -
- Density (g/cm³): 9,6
- Shear strength (MPa): -
- Tensile strength DIN EN 12797 (MPa): -
- Operating temperature of brazed joint (min/max) ± (°C): -

Applications
Silverware, precision metal parts, fashion accessories

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

Heat sources
Flame, induction heating, furnace

Delivery forms
Wire, rods, ribbon

Notes

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