



Brazing alloy in paste BrazeTec D5600.1

TD EN D 5600 REV. 2

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Oth er	ISO 17672:201 0	EN 1044:1999	ISO 3677
56	22	17	5	-	-	-	-	-	Ag 156	AG 102	-

Technical data:

Melting range (°C)	620-655
Working temperature (°C)	650
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	-
Flash point (°C)	-
Operating temperature of brazed joint (°C)	max 200
Tensile strength DIN EN 12797 (MPa)	with S235: 350; with S550: 430
Alloy density (g/cm³)	9,5
Paste density (g/cm³)	2,8 (20°C)
Metal content (%) of total weight	65
Grain size of brazing alloy powder (µm)	< 106
Viscosity (dPas)	1100-1300 (Haake Viscotester 02, Sp.2, 20 ± 2°C)
Cleaning agent	Braze Tec Agent P
Flux type within the paste	FH 10
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

Applications

Electrical industry, automotive

Operating conditions

Silver based alloy with excellent flow, capillarity and mechanical strength characteristics. Dosable paste, suitable for automated brazing process.

Suitable for brazing any steel, copper and copper alloys as well as nickel and nickel alloys.

Heat source

Flame, induction heating, furnace

Standard packaging

Jar

Residues are corrosive and have to be removed with water and mechanical rubbing.

The information reported in this document about our products and equipment as well as our systems and procedures are based on our research and our experience in the field of applied engineering and are merely recommendations.

Italbras S.p.A. cannot foresee all circumstances in which these information and our products will be used, therefore the user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility.

Italbras S.p.A. declines any liability for any loss, damage or injury howsoever arising (including any claim brought by third parties) as a result of the use of such information. Each warranty of suitability of our products and their use within the production processes of the user, must be agreed in written form. We reserve the right to make technical modifications to this document in the course of our product development.

Italbras S.p.A.

Strada del Balsego, 6 – 36100 Vicenza (I)

info@italbras.it - www.italbras.it -

Tel. +39 0444.3475-00 / Fax +39 0444.3475-01