



Brazing alloy BrazeTec Darifix 3

TD EN DARI3 REV. 1

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	DIN EN ISO 9453:2006
-	3	-	Rest	-	-	-	-	-	-	-	402

Technical data:

Melting range (°C)	230-250
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Electrical conductivity (m/Ωmm ²)	7,5
Elongation %	-
Density (g/cm ³)	7,3
Shear strength DIN EN 12797 (MPa)	with S235: 25; Cu: 30 ; Brass: 20
Operating temperature of brazed joint (min/max) ± (°C)	-

Applications

Plumbing technology, electrical industry

Operating conditions

Tin based brazing alloy, free from antimony and lead. Excellent flow, capillarity and mechanical strength characteristics. Used for joining steel, copper and copper alloys, as well as nickel and nickel alloys. Suitable for copper pipes installations for plumbing system.

Recommended fluxes

Soldaflux 7000

Heat source

Flame, induction heating, resistance

Forms

Triangular rod section 12x12x12 mm and 400 mm of length

Notes

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