



Brazing alloy in paste Innobrazo ML100

TD EN ML 100 REV. 2

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	99,9	-	-	-	-	-	-	-	Cu 110	CU 101	B-Cu100 - 1085

Technical data:

Melting range (°C)	1083
Working temperature (°C)	1120
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/cm³)	8,96
Paste density (g/cm³)	3,6 (20°C)
Metal content (%) of total weight	-
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	700-750 (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

Dosable copper based alloy. Excellent flow, capillarity, mechanical strength characteristics and joint filling. Good adhesion to surfaces and slow drying. Used for joining mild steels, carbon steel, stainless steel or cemented carbides. It is possible apply the paste up to 24h prior to brazing. Suitable for manual and automated brazing process.

Heat source

Furnace under protective atmosphere (H₂ , NH₃, H₂/N₂ - mixtures) Epsogas type (this paste shows excellent brazing properties, however, small flue dust residues may appear after brazing process, depending on the brazing conditions) or Endogas and furnace in vacuum (in case of strong vacuum, small residues of carbon may appear on mild steel joints, which can be easily removed by brushing).

Standard packaging

Jar

Steel parts are hardened after brazing. The paste can be used for gap filling up to 0.1 mm maximum.

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