



Brazing alloy in paste Innobrazo ML104

TD EN ML 104 REV. 1

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	96	-	4	-	-	-	-	-	-	-	B-Cu96Sn - 960/1060

Technical data:

Melting range (°C)	960-1060
Working temperature (°C)	1090
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/cm ³)	-
Paste density (g/cm ³)	3,4 - 3,6 (20°C)
Metal content (%) of total weight	-
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	700
Cleaning agent	-
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. Can be applied on the part up to 24h prior to brazing. Suitable for non-joined and low-joined steels.

Heat source

Furnace in vacuum and under protective atmosphere

Standard packaging

Jar

A good elongation of the brazed joints is guaranteed because of the low tin content.

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