



Brazing alloy in paste Innobrazo ML106

TD EN ML 106 REV. 2

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	94	-	6	-	-	-	-	-	-	-	B-Cu94Sn - 910/1040

Technical data:

Melting range (°C)	910-1040
Working temperature (°C)	1060
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)	3,7 (20°C)
Metal content (%) of total weight	-
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	600
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 very slow drying. The paste can be applied on the part up to 24h prior to brazing. Especially suitable for non-joined, low-joined and mid-joined steels, as well as high-joined steels and Cr and CrNi steels. Good resistance to corrosion (e.g seawater).

Heat source

Furnace under protective atmosphere (H₂, NH₃, H₂/N₂ -mixtures) and in vacuum

Standard packaging

Jar

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