



## Brazing alloy in paste Innobrazo ML320

TD EN ML 320 REV. 2

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	80	-	20	-	-	-	-	-	-	-	B-Cu80Sn - 800/890

### Technical data:

Melting range (°C)	800-890
Working temperature (°C)	950-1000
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)	-
Paste density (g/cm³)	3,6 (20°C)
Metal content (%) of total weight	-
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	-
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

### Operating conditions

Dosable copper based alloy with excellent flow, capillarity and mechanical strength characteristics and joint filling. Good adhesion to surfaces and average drying time. Used for joining copper and copper based alloy with melting point > 1000°C, as well as steel-copper and stainless steel-copper. This paste is not recommended for joining steel to steel because of brittleness.

### Heat source

Furnace under protective atmosphere (H<sub>2</sub>, NH<sub>3</sub>, H<sub>2</sub>/N<sub>2</sub> - mixtures) and in vacuum

### Standard packaging

Jar

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