



## Brazing alloy in paste Innobraze ML572

TD EN ML572 REV. 2

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Oth er	ISO 17672:201 0	EN 1044:1999	ISO 3677
72	28	-	-	-	-	-	-	-	Ag 272	AG 401	-

### Technical data:

Melting range (°C)	780
Working temperature (°C)	780
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	-
Flash point (°C)	-
Operating temperature of brazed joint (°C)	200
Tensile strength DIN EN 12797 (MPa)	with S235: 340; with E295: 390
Alloy density (g/cm³)	10
Paste density (g/cm³)	4,4 at 20°C
Metal content (%) of total weight	-
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	600-700 (Haake Viscotester 02, Sp.2, 20 ± 2°C)
Cleaning agent	Water
Flux type within the paste	-
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

### Applications

Electrical industry, automotive

### Operating conditions

Silver based alloy with excellent flow, capillarity and mechanical strength characteristics. Good electrical conductivity (app. 48 m / ? mm <sup>2</sup>) and heat conductivity (about 335 W / mK).

### Heat source

Furnace in vacuum or under protective atmosphere. Brazing process does not generate residues.

### Standard packaging

Jar

In vacuum, a considerable amount of silver evaporates at brazing temperatures above 1000 ° C. Use Argon while brazing with partial pressure (e.g. 10 mbar) to prevent silver from evaporating.

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