



Brazing alloy in paste Innobrazte ML986

TD EN ML986 REV. 2

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	Rest	-	7	-	7	-	-	-	-	-	B-Cu86SnP - 650/700

Technical data:

Melting range (°C)	650-700
Working temperature (°C)	840
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)	4,8-4,9 (20°C)
Metal content (%) of total weight	> 92
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. Excellent flow, capillarity, mechanical strength characteristics and joint filling. Good adhesion to surfaces and fast drying (about 1 h). No hardening or flaking problems. The paste can be applied on the part up to 24h prior to brazing, depending on the joint shape and on the paste amount to be used. Suitable for joining copper and copper based alloys. It is not allowed to use this paste for joining steel, nickel and nickel based alloys, because of brittleness arising from phosphorus.

Heat source

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

Standard packaging

Jar
Brazing process do not generate binder residues on the workpiece. In particular on copper-copper joints, are achieved shear strenghts that match the base metal strenght. Thanks to the tin content in the alloy, the brazing temperature is particularly low, however ensures a good ductility of the joint.

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