



Brazing alloy BrazeTec S606

TD EN S606 REV. 3

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
0,6	93,2	-	-	-	6,2	-	-	-	-	-	-

Technical data:

Melting range (°C)	710 - 870
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	8,1
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with Cu:250
Operating temperature of brazed joint (min/max) ± (°C)	-55/+150

Applications

Refrigeration, air conditioning and electrical industry, plumbing technology

Operating conditions

Copper based alloy, containing silver and phosphorus. Excellent flow, capillarity and mechanical strength characteristics. Used for joining copper and copper alloys. It is not allowed to use this alloy for joining steels, iron, nickel and cobalt, as it will be formed brittle phases in the joint. Brazing alloy not allowed to be used while operating in sulphur containing atmosphere, due to the credice corrosion phenomena.

Recommended fluxes

Due to its phosphorus content, it is not necessary to use an additional flux for brazing only copper to copper.

Heat sources

Flame, induction heating

Delivery forms

Rods

Notes

In refrigeration and air conditioning industries it can be used for service temperatures down to -50°C.

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