



Brazing alloy BrazeTec S6

TD EN S6 REV. 7

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
6	87	-	-	-	7	-	-	-	CuP 283	-	-

Technical data:

Melting range (°C)	645-720
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)	8,25
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	-55/+150

Applications

Refrigeration, air conditioning and electrical industry, plumbing technology

Operating conditions

Silver based brazing alloy, containing 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 crevice 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, resistance, furnace under protective atmosphere

Delivery forms

Wire, rods, rings, preforms

Notes

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