Brazing alloy BrazeTec S92

Composition (% in weight)

<table>
<thead>
<tr>
<th>Ag</th>
<th>Cu</th>
<th>Zn</th>
<th>Sn</th>
<th>Si</th>
<th>P</th>
<th>Mn</th>
<th>Ni</th>
<th>Other</th>
<th>ISO 17672:2010</th>
<th>EN 1044:1999</th>
<th>ISO 3677</th>
</tr>
</thead>
<tbody>
<tr>
<td>-</td>
<td>Rest</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>7,8</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>CuP 182</td>
<td>CP 201</td>
<td>-</td>
</tr>
</tbody>
</table>

Technical data:

- **Melting range** (°C): 710 - 770
- **Working temperature** (°C): 720
- **Melting range according to DSC measurement** (°C): -
- **Min. brazing temperature** (°C): -
- **Electrical conductivity** (m/Ω mm²): -
- **Elongation %**: -
- **Density** (g/cm³): 8
- **Shear strength** (MPa): -
- **Tensile strength DIN EN 12797** (MPa): Su 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 phosphorus. Excellent flow, capillarity and mechanical strength characteristics. Used for joining copper and copper alloys. Further it is not allowed to use this alloy for joining steel, iron, nickel and cobalts, 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, furnace under protective atmosphere

Delivery forms
Wire, rods, rings, preforms

Notes
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