



Brazing alloy BrazeTec S93 special

TD EN S93 sp REV. 3

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	Rest	-	-	0,001-0,05	7	-	-	-	-	-	-

Technical data:

Melting range (°C)	710 - 820
Working temperature (°C)	730
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	5
Density (g/cm ³)	8,05
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	Su Cu: 250
Operating temperature of brazed joint (min/max) ± (°C)	-55/+150

Applications

Refrigeration and air conditioning industry, plumbing technology, electrical motors

Operating conditions

Phosphorus containing brazing alloy. Excellent flow, capillarity and mechanical strength characteristics. Used for joining copper and copper alloys.

Recommended fluxes

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Heat sources

Flame, induction heating, resistance

Delivery forms

Wire, rods, ribbon, rings, preforms, powder

Notes

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Italtbras S.p.A.

Strada del Balsego, 6 – 36100 Vicenza (I)
info@italbras.it - www.italbras.it -
 Tel. +39 0444.3475-00 / Fax +39 0444.3475-01