



Brazing alloy BrazeTec S94

TD EN S 94 REV. 3

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	Rest	-	-	-	6,2	-	-	-	CuP 179	CP 203	-

Technical data:

Melting range (°C)	710 - 890
Working temperature (°C)	760
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	5
Density (g/cm ³)	8,1
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

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 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, furnace under protective atmosphere

Delivery forms

Rods, rings

Notes

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