



Brazing alloy BrazeTec Soldamoll 235

TD EN SLDM235 REV. 1

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
-	-	-	95	-	-	-	-	5 Sb	-	-	S-Sn95Sb5

Technical data:

Melting range (°C)	230-240
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	6,2
Elongation %	-
Density (g/cm ³)	7,2
Shear strength DIN EN 12797 (MPa)	Cu: 30 ; Brass: 20 ; S235: 30
Operating temperature of brazed joint (min/max) ± (°C)	-

Applications

Plumbing technology, electrical industry

Operating conditions

Tin based brazing alloy, free from antimony and lead. Excellent flow, capillarity and mechanical strength characteristics. Used for joining steel, copper and copper alloys, as well as nickel and nickel alloys.

Recommended fluxes

Soldaflux 7000

Heat sources

Flame, induction heating, resistance

Delivery forms

Wire, rods, ribbon, rings, preforms

Notes

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