



Brazing alloy BrazeTec 2500

TD EN 2500 REV. 4

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672:2010	EN 1044:1999	ISO 3677
25	40	35	-	-	0	-	-	-	AG 225	AG 205	-

Technical data:

Melting range (°C)	700-790
Working temperature (°C)	780
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	25
Density (g/cm ³)	8,9
Shear strength DIN EN 12797 (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with S 235:380; with E 295:430
Operating temperature of brazed joint (min/max) ± (°C)	200

Applications

Refrigeration, air conditioning and electrical industry, plumbing technology

Operating conditions

Silver based brazing alloy with excellent flow, capillarity and mechanical strength characteristics. Used for brazing any steels, copper and copper alloys, as well as nickel and nickel alloys.

Recommended fluxes

N1/T, Super 1, N2/E, H paste, H sprayable, RS/A, FN/E, D 98, H 280

Heat sources

Flame, induction heating, furnace in vacuum and under protective atmosphere

Delivery forms

Wire, rods, ribbon, rings, preforms, powder

Notes

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