



## Brazing alloy in paste BrazeTec 897 ML442

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	-	-	-	-	10,1	-	Rest	14 Cr	Ni 710	NI 107	-

### Technical data:

Melting range (°C)	890
Working temperature (°C)	980
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	-
Flash point (°C)	-
Operating temperature of brazed joint (°C)	-
Tensile strength DIN EN 12797 (MPa)	-
Alloy density (g/cm <sup>3</sup> )	7,9
Paste density (g/cm <sup>3</sup> )	3,9 (20°C)
Metal content (%) of total weight	85
Grain size of brazing alloy powder (µm)	< 106
Viscosity (dPas)	450-650 (Haake Viscotester 02, Sp.2, 20 ± 2°C)
Cleaning agent	Water
Flux type within the paste	Absent
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

### Applications

Refrigeration and air conditioning industry, heating system, automotive

### Operating conditions

Homogeneous mixture of nickel based powder. Finely dissolved in a water-based binder system, with the possibility of manual dosing or manual application with excellent fluidity, capillarity and mechanical resistance. Excellent flow, capillarity and mechanical strength characteristics. Used for joints in copper, copper alloys, steel, stainless steel, nickel, nickel alloys, cobalt, cobalt alloys, and in certain conditions special alloys.

### Heat source

Furnace in vacuum and under protective atmosphere

### Standard packaging

Jar

### Note

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