



Brazing alloy BrazeTec Darifix 3

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044	ISO 3677
-	3	-	Rest	-	-	-	-	ISO 9453:402	-	-	S-Sn97Cu3

Technical data:

Melting range (°C)	227 - 310
Working temperature (°C)	320 - 350
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm²)	7,5
Elongation %	-
Density (g/cm³)	7,4
Shear strength (MPa)	with S235: 25; Cu: 30 ; Brass: 20
Tensile strength DIN EN 12797 (MPa)	-
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. Suitable for copper pipes installations for plumbing system.

Recommended fluxes

Soldaflux 7000

Heat sources

Flame, induction heating, resistance

Delivery forms

Triangular rod section 12x12x12 and 400 mm of length

Notes

Tensile strength with Cu: 24,3 Mpa

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