



Brazing alloy BrazeTec Soldamoll 220 A

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044	ISO 3677
3,5	-	-	Rest	-	-	-	-	ISO 9453:703	-	-	S-Sn96Ag4

Technical data:

Melting range (°C)	221
Working temperature (°C)	260 - 280
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm²)	7,5 (ref. metal part)
Elongation %	-
Density (g/cm³)	7,4 (ref. metal part)
Shear strength (MPa)	Cu: 30; Brass: 20; S235: 25
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

Core alloy with acid flux. It is possible to improve oxides removing process by adding Soldaflux 7000 flux.

Heat sources

Flame, induction heating, resistance

Delivery forms

Core wire, core rods, core rings

Notes

Self life: 6 months, in the original sealed container at storage temperatures between +5 to +30 °C

Tensile strength with Cu: 39 Mpa

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