



Brazing alloy BrazeTec Soldamoll 220

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
Elongation %	-
Density (g/cm³)	7,4
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

Soldaflux 7000

Heat sources

Flame, induction heating, resistance

Delivery forms

Wire, rods, ribbon, rings, preforms

Notes

Tensile strength with Cu: 39 Mpa

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