



## Brazing alloy BrazeTec BlueBrazo 3510 U

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
35	32,6	20	2	0,4	-	10	-	-	-	-	B-Ag35CuZnMnSn(Si)-680/700

### Technical data:

Melting range (°C)	-
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	680-700
Min. brazing temperature (°C)	700
Electrical conductivity (m/Ω mm <sup>2</sup> )	2,4
Elongation %	14
Density (g/cm <sup>3</sup> )	8,6
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with S 235: 320;with E 295: 420
Operating temperature of brazed joint (min/max) ± (°C)	-

### Applications

Refrigeration and air conditioning industry.

### Operating conditions

Silver based brazing alloy, flux coated. 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

Flux as coating of the ISO 18496 FH 10 rod. Flux residues are corrosive and water-soluble, we suggest to remove them with water and / or mechanical brushing.

### Heat sources

Flame, induction heating

### Delivery forms

Coated rods

### Notes

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