



Brazing alloy Brazetec BlueBrazec 3510

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	-	-	-	-	-

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 ²)	2,4
Elongation %	14
Density (g/cm ³)	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 alloy with excellent flow characteristics. Suitable for joining steel, copper, copper alloys, as well as nickel and nickel alloys.

Recommended fluxes

N1/T, Super 1, N2/E, H paste, RS/A, FN/E, D 98, H 280

Heat sources

Flame, induction heating, furnace

Delivery forms

Wire, rods, rings, preforms

Notes

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