



Brazing alloy BrazeTec 3

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	3	-	Rest	-	-	-	-	-	-	-	S-Sn97Cu3

Technical data:

Melting range (°C)	227-310
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	7,5
Elongation %	-
Density (g/cm ³)	7,3
Shear strength (MPa)	with St 37: 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 copper, brass and red brass. BrazeTec 3 meets the requirements of the working sheet "GW2" and "GW 7" of DVGW (German Association of Gas and Water). BrazeTec 3 is approved and registered by DVGW (DV-0106CL0487) and has been awarded by the Gütegemeinschaft Kupferrohr e.V. (The copper tube Manufacturers Quality Association). Therefore it is suitable for copper pipes installations for plumbing system.

Recommended fluxes

Soldaflux 7000

Heat sources

Flame, induction heating, resistance

Delivery forms

Wire

Notes

DIN EN ISO 9453: 402

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Italbras S.p.A.

Strada del Balsego, 6 – 36100 Vicenza (I)
info@italbras.it - www.italbras.it -
 Tel. +39 0444.3475-00 / Fax +39 0444.3475-01