



Brazing alloy in paste BrazeTec D5600.1

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
56	22	17	5	-	-	-	-	-	Ag 156	AG 102	-

Technical data:

Melting range (°C)	620-655
Working temperature (°C)	650
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	-
Flash point (°C)	-
Operating temperature of brazed joint (°C)	max 200
Tensile strength DIN EN 12797 (MPa)	with S235: 350; with S550: 430
Alloy density (g/cm ³)	9,5
Paste density (g/cm ³)	2,8 (20°C)
Metal content (%) of total weight	65
Grain size of brazing alloy powder (µm)	< 106
Viscosity (dPas)	1100-1300 (Haake Viscotester 02, Sp.2, 20 ± 2°C)
Cleaning agent	Braze Tec Agent P
Flux type within the paste	FH 10
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

Applications

Electrical industry, automotive

Operating conditions

Silver based alloy with excellent flow, capillarity and mechanical strength characteristics. Dosable paste, suitable for automated brazing process. Suitable for brazing any steel, copper and copper alloys as well as nickel and nickel alloys.

Heat source

Flame, induction heating, furnace

Standard packaging

Jar

Note

Residues are corrosive and have to be removed with water and mechanical rubbing.

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