



Brazing alloy in paste Innobrazo ML104

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	96	-	4	-	-	-	-	-	-	-	B-Cu96Sn - 960/1060

Technical data:

Melting range (°C)	960-1060
Working temperature (°C)	1090
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	-
Flash point (°C)	-
Operating temperature of brazed joint (°C)	-
Tensile strength DIN EN 12797 (MPa)	-
Alloy density (g/cm ³)	-
Paste density (g/cm ³)	3,4 - 3,6 (20°C)
Metal content (%) of total weight	-
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	700
Cleaning agent	-
Flux type within the paste	Absent
Shelf life	6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

Applications

Refrigeration and air conditioning industry, heating system, automotive

Operating conditions

Dosable copper based alloy. Excellent flow, capillarity, mechanical strength characteristics and joint filling. Good adhesion to surfaces and slow drying. Can be applied on the part up to 24h prior to brazing. Suitable for non-joined and low-joined steels.

Heat source

Furnace in vacuum and under protective atmosphere

Standard packaging

Jar

Note

A good elongation of the brazed joints is guaranteed because of the low tin content.

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