



## Brazing alloy in paste Innobrazte ML106

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	94	-	6	-	-	-	-	-	-	-	B-Cu94Sn - 910/1040

### Technical data:

Melting range (°C)	910-1040
Working temperature (°C)	1060
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 <sup>3</sup> )	-
Paste density (g/cm <sup>3</sup> )	3,7 (20°C)
Metal content (%) of total weight	-
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	600
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 very slow drying. The paste can be applied on the part up to 24h prior to brazing. Especially suitable for non-joined, low-joined and mid-joined steels, as well as high-joined steels and Cr and CrNi steels. Good resistance to corrosion (e.g seawater).

### Heat source

Furnace under protective atmosphere (H<sub>2</sub>, NH<sub>3</sub>, H<sub>2</sub>/N<sub>2</sub> -mixtures) and in vacuum

### Standard packaging

Jar

### Note

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