



Brazing alloy in paste Innobrazo ML200

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	Rest	-	12	-	-	-	-	-	-	-	B-Cu88Sn - 820/990

Technical data:

Melting range (°C)	820-990
Working temperature (°C)	1040
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)	8,6
Paste density (g/cm ³)	3,3 (20°C)
Metal content (%) of total weight	-
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	250-350 (Haake Viscotester 02, Sp.2, 20 ± 2°C)
Cleaning agent	Water
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

Operating conditions

Dosable copper based alloy with excellent flow, capillarity and mechanical strength characteristics. Good adhesion to surfaces and slow drying at room temperature. The paste can be applied on the part up to 24h prior to brazing. Used for joining copper, non and low-joined steels. Furnace under protective atmosphere at high dew point.

Heat source

Furnace under protective atmosphere (H₂, NH₃, H₂/N₂ - mixtures) and in vacuum

Standard packaging

Jar

Note

The paste can be used for filling wide gaps (> 0,1 mm). Because of the limited elongation point of the alloy, it must not be used for steel joints subjected to high mechanical stress.

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