



Brazing alloy in paste Innobraze ML572

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
72	28	-	-	-	-	-	-	-	Ag 272	AG 401	-

Technical data:

Melting range (°C)	780
Working temperature (°C)	780
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	-
Flash point (°C)	-
Operating temperature of brazed joint (°C)	200
Tensile strength DIN EN 12797 (MPa)	with S235: 340; with E295: 390
Alloy density (g/cm ³)	10
Paste density (g/cm ³)	4,4 at 20°C
Metal content (%) of total weight	-
Grain size of brazing alloy powder (µm)	-
Viscosity (dPas)	600-700 (Haake Viscotester 02, Sp.2, 20 ± 2°C)
Cleaning agent	Water
Flux type within the paste	-
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. Good electrical conductivity (app. 48 m / Ω mm²) and heat conductivity (about 335 W / mK).

Heat source

Furnace in vacuum or under protective atmosphere. Brazing process does not generate residues.

Standard packaging

Jar

Note

In vacuum, a considerable amount of silver evaporates at brazing temperatures above 1000 ° C. Use Argon while brazing with partial pressure (e.g. 10 mbar) to prevent silver from evaporating.

The information reported in this document about our products and equipment as well as our systems and procedures are based on our research and our experience in the field of applied engineering and are merely recommendations. Italbras S.p.A. cannot foresee all circumstances in which these information and our products will be used, therefore the user must verify the suitability of our products and processes for the use or application intended by him on his own responsibility. Italbras S.p.A. declines any liability for any loss, damage or injury howsoever arising (including any claim brought by third parties) as a result of the use of such information. Each warranty of suitability of our products and their use within the production processes of the user, must be agreed in written form. We reserve the right to make technical modifications to this document in the course of our product development.

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