



## Brazing alloy in paste BrazeTec 1080 ML4127

### Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	-	-	-	4,5	-	-	Rest	14 Cr; 3,13 B; 4,5 Fe	Ni 610	NI 1A1	-

### Technical data:

Melting range (°C)	980-1070
Working temperature (°C)	1175
Melting range according to DSC measurement (°C)	-
Minimum brazing temperature (°C)	-
Boiling point (°C)	400 °C to 1 bar
Flash point (°C)	-
Operating temperature of brazed joint (°C)	-
Tensile strength DIN EN 12797 (MPa)	-
Alloy density (g/cm <sup>3</sup> )	7,8
Paste density (g/cm <sup>3</sup> )	3,9 (20°C)
Metal content (%) of total weight	85
Grain size of brazing alloy powder (µm)	< 63
Viscosity (dPas)	400-550 (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, automotive

### Operating conditions

Homogeneous mixture of nickel based powder. Finely dissolved in a binder system water based; dosable or spreadable manually. Good flow, capillarity and mechanical strength characteristics. Used for joining copper, copper alloys, nickel, nickel alloys, as well as cobalt, cobalt alloys. Also used for non-joined, semi-joined and high-joined steels and in certain conditions special alloys.

### Heat source

Furnace in vacuum and under protective atmosphere

### Standard packaging

Jar

### Note

Packaged in jar or buckets. Must be stirred in case of condensed water on the top.

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](mailto:info@italbras.it) - [www.italbras.it](http://www.italbras.it) -  
 Tel. +39 0444.3475-00 / Fax +39 0444.3475-01