



Brazing alloy BrazeTec S5 special

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
5	Rest	-	-	0,001-0,01	6	-	-	-	CuP 281a	CP 104	-

Technical data:

Melting range (°C)	645 - 815
Working temperature (°C)	710
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	5
Elongation %	8
Density (g/cm ³)	8,2
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	with Cu:250
Operating temperature of brazed joint (min/max) ± (°C)	-55/+150

Applications

Refrigeration, air conditioning and electrical industry, plumbing technology

Operating conditions

Silver based brazing alloy, containing phosphorus. Excellent flow, capillarity and mechanical strength characteristics. Used for joining copper and copper alloys. It is not allowed to use this alloy for joining steels, iron, nickel and cobalt as it will be formed brittle phases in the joint. Brazing alloy not allowed to be used while operating in sulphur containing atmosphere, due to the crevice corrosion phenomena.

Recommended fluxes

Due to its phosphorus content, it is not necessary to use an additional flux for brazing only copper to copper.

Heat sources

Flame, induction heating, resistance, furnace under protective atmosphere

Delivery forms

Wire, rods, ribbon, rings, preforms, powder

Notes

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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