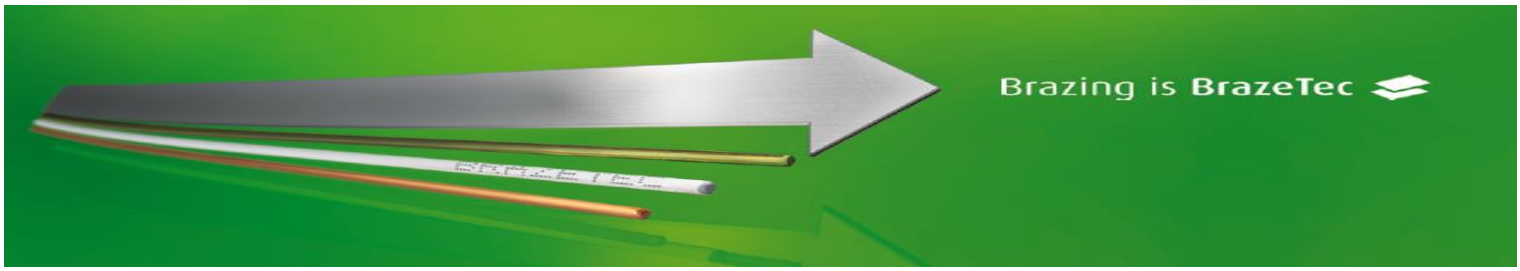
TECHNICAL DATASHEET



Brazing alloy BrazeTec S86

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	Rest	-	7	-	6,8	-	-	-	CuP 386	CP 302	-

Technical data:

Melting range (°C)	650-700
Working temperature (°C)	700
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductibility (m/Ω mm²)	-
Elongation %	-
Density (g/cm^3)	8
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	Su Cu: 250
Operating temperature of brazed joint (min/max) ± (°C)	-55/+150

Applications
Refrigeration, air conditioning and electrical industry, plumbing technology

Operating conditions
Copper based alloy, containing phosphorus and tin. Excellent flow, capillarity and mechanical strength characteristics. Used for joining copper and copper alloys. It is not allowed to use this alloy for joining steel, iron, nickel and cobalts, 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 credice 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, furnace under protective atmosphere

Delivery forms
Wire, rod, rings, preforms

Notes
BrazeTec S 86 alloy is brittle, due to the presence of tin, particularly when used in automated brazing process which may deform or bend wire. Therefore, it is recommended that the temperature is at least +10 ° C during use. In any case, the process of wire deformation and bending may be critical and must be carried out by qualified personal and with the appropriate machines.

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