



Brazing alloy BrazeTec Soldamoll 210 C

Composition (% in weight)

Ag	Cu	Zn	Sn	Si	P	Mn	Ni	Other	ISO 17672	EN 1044:1999	ISO 3677
-	1	-	99	-	-	-	-	-	-	-	S-Sn99Cu1

Technical data:

Melting range (°C)	270-290
Working temperature (°C)	-
Melting range according to DSC measurement (°C)	-
Min. brazing temperature (°C)	-
Electrical conductivity (m/Ω mm ²)	-
Elongation %	-
Density (g/cm ³)	-
Shear strength (MPa)	-
Tensile strength DIN EN 12797 (MPa)	-
Operating temperature of brazed joint (min/max) ± (°C)	-

Applications

Plumbing technology, electrical industry

Operating conditions

Tin based brazing alloy, free from antimony and lead. Excellent flow, capillarity and mechanical strength characteristics. Used for joining steel, copper and copper alloys, as well as nickel and nickel alloys. Suitable for copper pipes installations for plumbing system.

Recommended fluxes

Core alloy with colophony flux type 1.1.2.B / ROM1 (2,4+ -0,2%)

Heat sources

Flame, induction heating, resistance

Delivery forms

Core wire, core rods, core rings

Notes

Self life: 6 months, in the original sealed container at storage temperatures between +5 to +30 °C

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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