Solvent based brazing paste
BrazeTec CSH 610 TD is especially developed for the copper-brass radiator brazing process (CuproBraze). It is especially designed for brazing the tube-to-header joints and can be applied by so called slurry machines. The binder system is solvent based and ensures fast drying, good adhesion and a residue free burnout under protective atmosphere.

Standard
Brazing alloy
BrazeTec Standard CPO 610
Filler
BrazeTec Standard CuP8

Nominal composition [wt.-%]
Brazing alloy Cu Rem.; Sn 9.3; P 6.5; Ni 5.7
Filler Cu Rem.; P 8.3
Permitted impurities max. [wt.-%] Al 0.010; Bi 0.030; Cd 0.010; Pb 0.025; Zn 0.050; Zn + Cd 0.050

Technical data
Melting range of brazing alloy approx. 595 - 620 °C
Working temperature approx. 650 °C
Metal content > 80 wt.-%
Flux content of the brazing paste < 3 wt.-%
Density of brazing paste approx. 3.2 g/cm³ (20 °C)
Grain size of brazing alloy powder < 106 µm
Viscosity 9 ± 1.5 Pa s (Cone-Plate; 150 µm; D= 1/s; 20 °C)
Drying temperature about 100 - 120 °C at work piece
Cleaning agent BrazeTec Cleaning Agent TD
Shelf life min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30°C stir well before use

Packaging
Standard 10; 25 kg

Applications
BrazeTec CSH 610 TD is applied by special equipment (slurry machines) on the header plates. Drying takes place at temperatures between 100 °C and 120 °C at the header plate. The paste is suitable to braze wider gaps between the tubes and the header plate. The brazing process has to be carried out in protective atmosphere using nitrogen at a brazing temperature of about 650 °C depending on brazing furnace, furnace cycle, size of parts etc.