Solvent based brazing paste
BrazeTec CSO 610.2 TD is especially developed for the copper-brass radiator brazing process (CuproBraze). It is especially designed for brazing the tank-to-header joints. The binder system is solvent based and ensures a good adhesion and a residue free burnout under protective atmosphere.

Standard
BrazeTec Standard CPO 610

Nominal composition [wt.-%] Cu Rem.; Sn 9.3; P 6.5; Ni 5.7
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 approx. 90 wt.-%
Flux content of the brazing paste < 3 wt.-%
Grain size of brazing alloy powder < 90 µm
Viscosity 560 ± 60 Pa s (Cone-Plate; 150 µm; D= 0.5/s; 20 °C)
Flash point of solvent approx. 73 °C
Evaporation temperature of binder approx. 180 - 420 °C at 1 bar
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 25 kg

Applications
BrazeTec CSO 610.2 TD is applied by air pressure or screw dispenser techniques on the gap between tank and header plates. Drying takes place at temperatures between 100°C and 120°C at the base material. 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.
Best brazing results are achieved when the air inside the tanks has been replaced by nitrogen prior to brazing.

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